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Attorney Docket No. YAMAP0398USB

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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Docket No. YAMAP0398USB

Assistant Commissioner for Patents
Washington, D.C. 20231

Sir:

This is a request for filing a

Continuation

Divisional

application under 37 CFR 1.53, of pending prior application

Serial No.: 08/861,943

Filed: May 22, 1997

Applicant: Miyamoto et al.

For: OPTICAL INFORMATION MEDIUM, AND METHOD AND APPARATUS
FOR FABRICATING THE SAME

Attorney Docket No. YAMAP0398USB

1. [X] Enclosed is a copy of the prior application, including the oath or declaration as originally filed.

I hereby verify that the attached papers are a true copy of prior Application Serial No. 08/861,943 as originally filed on May 22, 1997 which is a division of prior application Serial No. 08/599,181 filed February 9, 1996 (U.S. Patent No. 5,681,634 issued October 28, 1997) and further that this statement was made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of United States Code and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

2. [X] The filing fee is calculated below.

**CLAIMS AS FILED IN THE PRIOR APPLICATION, LESS
ANY CLAIMS CANCELLED BY AMENDMENT BELOW**

	Number <u>filed</u>	Number <u>extra</u>	Rate	Fee
Total claims	1 - 20 =	0 x	\$ 18	\$ -----
Independent claims	1 - 3 =	0 x	\$ 78	\$ -----
Basic Fee (minimum amount required)				\$ <u>760.00</u>
Total Filing Fee				\$ <u>760.00</u>

3. [X] The Commissioner is hereby authorized to charge any additional fees which may be required or credit any overpayment to Account No. 18-0988.

4. [X] A check in the amount of \$ 760.00 is enclosed.

5. [X] Cancel in this application original claims
1-49 and 51-56

of the prior application before calculating the filing fee, leaving only claims
50

At least one original independent claim must be retained for filing purposes).

Attorney Docket No. YAMAP0398USB

6. [X] Amend the specification by inserting before the first line the sentence:
--This is a [] continuation, [X] division of application Serial No.
08/861,943, filed May 22, 1997 which is a division of application
Serial No. 08/599,181 filed February 9, 1996 (U.S. Patent No.
5,681,634 issued October 28, 1997).
7. [] Transfer the drawings from the prior application to this application and
abandon said prior application as of the filing date accorded this
application. A duplicate copy of this sheet is enclosed for filing in the
prior application file. (May only be used if signed by person authorized
by §1.138 and before payment of base issue fee).
- a. [] The drawings as originally filed and the formal drawings
approved by the Examiner during prosecution of
application Serial No. _____ are enclosed.
8. [x] Priority of the following Application Serial Numbers is claimed under
35 USC §119.

<u>Serial No.</u>	<u>Filing Date</u>	<u>Country</u>
7-27086	2/15/95	Japan
7-58934	3/17/95	Japan
7-58933	3/17/95	Japan

- a. [x] The certified copies have been filed on June 5, 1996
in prior U.S. application Serial No. 08/599,181, (U.S.
Patent No. 5,681,634) which prior application was filed
on February 9, 1996.

9. [X] The prior application is assigned of record to

Matsushita Electric Industrial Co., Inc. (copy enclosed) at Reel 7875,
Frame 0613.

10. [X] The power of attorney in the prior application is to

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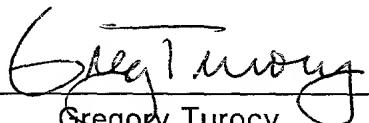
- a. [] The power appears in the original papers in the prior application, in response to Notice to File Missing Parts of Application. (copy enclosed)
- b. [] Since the power does not appear in the original papers, a copy of the power in the prior application is enclosed.
- c. [X] Address all future communications to

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11. [] A Preliminary Amendment is enclosed.

12. [] An Information Disclosure Statement is enclosed.

Date: August 4, 1999



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216/621-1113

[X] Filed under §1.34(a)

P13331

OPTICAL INFORMATION MEDIUM, AND
METHOD AND APPARATUS FOR FABRICATING THE SAME

BACKGROUND OF THE INVENTION

1. Field of the Invention:

5 The present invention relates to an optical information medium where two optical information substrates are bonded together, and a method and an apparatus for fabricating the same.

2. Description of the Related Art:

10 In order to enhance the density of an optical disk, reducing the wavelength of a reproduced laser beam and increasing the numerical aperture (NA) of an objective lens are required. However, increasing the NA of an objective lens makes the allowable tilt of a disk very small. For example, for a substrate with a thickness of 1.2 mm which is the thickness of CDs, the tilt of the substrate allowable for an objective lens with an NA of 0.6 is about 0.25°. This is equal to the error occurring at the mounting of an optical head to a player, meaning that no allowance is left for the tilt of an optical disk due to a shape change of the disk. Such an optical disk is not practical.

15 The allowable range for the tilt of a disk can be widened by reducing the thickness of a substrate. Thus, a practical optical disk with high density used for an objective lens with high NA can be realized. For example, by reducing the thickness of the substrate to 0.6 mm which is a half of the thickness of CDs, the tilt allowable for an objective lens with an NA of 0.6 is as high as about 0.75°. In this case, even if an error of 0.25° arises at the mounting of an optical head to a player, a tilt of the disk of 0.5° due to a shape change of the

disk is allowed.

An optical disk composed of a single thin substrate tends to bend down by its own weight. To avoid this problem, it is recommended to bond two substrates together. This serves, not only to increase the mechanical strength, but also to double the capacity of the disk by using two sides for information recording.

Figure 1 is a sectional view of a typical optical disk having two substrates bonded together with a radiation curable resin. Referring to Figure 1, a first substrate 1 has a first information signal surface 2, on which a first reflection film 3 made of metal and the like including aluminum as a main component is formed. A second substrate 4 has a second information signal surface 5, on which a second reflection film 6 made of the same material as the first reflection film 3 is formed. A layer of a radiation curable resin 7 is formed between the first and second reflection films 3 and 6, which are facing each other, so as to bond the first and second substrates 1 and 4 together.

Referring to Figures 2A to 2D, a conventional method for fabricating such an optical disk will be described (Japanese Laid-Open Patent Publication No. 6-238846). The first substrate 1 having the first information signal surface 2 is formed with a transparent resin such as polycarbonate by injection molding and the like. The first reflection film 3 is then formed on the first information signal surface 2 of the first substrate 1 by sputtering, vapor deposition, and the like. Also, the second substrate 4 having the second informa-

tion signal surface 5 is formed by injection molding and the like, and the second reflection film 6 is formed on the second information signal surface 5 of the second substrate 4 by sputtering and vapor deposition. The first and second reflection films 3 and 6 are made of metal including aluminum as a main component. Then, while the first substrate 1 being rotated at low speed, the radiation curable resin 7 is applied to the surface of the first substrate 1 on which the first reflection film 3 is formed, forming a donut-shaped resin layer (Figure 2A). The second substrate 4 is then placed on the radiation curable resin 7 so that the second reflection film 6 on the second information signal surface 5 of the second substrate 4 faces the radiation curable resin 7 (Figure 2B). The first and second substrates 1 and 4 are then rotated together at high speed to allow the radiation curable resin to spread in the space between the first and second substrates 1 and 4 (Figure 2C). The radiation curable resin is irradiated with radioactive rays (UV rays in Figure 2D) through the second substrate 4 and the second reflection film 6 formed thereon, to cure the radiation curable resin and thus to bond the two substrates integrally (Figure 2D).

In this conventional example, each of the two bonded substrates has an information signal surface, and the reflection film is formed on each information signal surface. The reflection film allows a slight amount of radioactive rays to pass therethrough and thus causing the radiation curable resin to be cured. For example, when the reflection film is made of aluminum and irradiated with UV rays, the UV transmittance of the aluminum film is 1% or less, which is large enough to cure the

resin sufficiently.

The disk with bonded thin substrates has such a large capacity that the capacity of only one side of the disk is enough for most software. Accordingly, one of the bonded substrates can be a transparent dummy substrate. In this case, the radiation curable resin can be rapidly and easily cured with radioactive rays passing through the transparent substrate (Japanese Laid-Open Patent Publication Nos. 5-63668 and 5-195011).

Alternatively, a semi-transparent film can be formed on one of the two substrates, and the two information signal surfaces can be accessed from one side of the disk. In this case, the radiation curable resin can be rapidly and easily cured with radioactive rays through the semi-transparent film.

As described above, in the above conventional method for fabricating a disk with two substrates bonded together, a radiation curable resin is applied to one of the substrates to form a donut-shaped resin layer while the substrate is being rotated at low speed, and the radiation curable resin is allowed to spread in a space between the two substrates while the two substrates are being rotated at high speed. In this case, when the high-speed rotation of the two substrates starts before the radiation curable resin spreads toward the inner circumferences of the substrates, the inner circumference portion of the disk is not supplied with a sufficient amount of resin. The resultant disk is inferior in strength. On the contrary, when the high-speed rotation of the two substrates starts only after the resin has

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sufficiently spread in the space between the two substrates, the resin tends to protrude to center holes of the substrates. This causes troubles such as decentering when the resultant disk is mounted on a turntable of a player.

SUMMARY OF THE INVENTION

The disk-shaped optical information medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein the optical information medium further includes a stopper for preventing the radiation curable resin from protruding into the center holes of the substrates, and a space between the first and second substrates of at least a half of a clamp region for clamping the optical information medium is filled with the resin.

In one embodiment of the invention, the stopper includes at least one concave portion formed on at least one of the first and second substrates.

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In another embodiment of the invention, the concave portion is a ring-shaped groove which is substantially concentric with the center holes of the substrates.

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In still another embodiment of the invention, the stopper includes at least one concave portion formed on one of the first and second substrates and at least one

convex portion formed on the other substrate.

In still another embodiment of the invention, the concave portion is disposed to face the convex portion.

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In still another embodiment of the invention, the stopper is formed at a position closer to the center holes of the substrates with respect to the center of the clamp region, and the radiation curable resin spreads to the position of the stopper.

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In still another embodiment of the invention, the stopper is formed at a position farther from the center holes of the substrates with respect to the center of the clamp region, and another resin layer is formed on a portion of the substrates closer to the center holes with respect to the stopper.

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In still another embodiment of the invention, the another resin layer includes a radiation curable resin having a viscosity higher than the radiation curable resin for bonding the first and second substrates together.

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In still another embodiment of the invention, the stopper includes a sealant layer.

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In still another embodiment of the invention, the sealant layer is formed by printing a radiation curable resin.

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In still another embodiment of the invention, the sealant layer is made of a hot melt adhesive.

Alternatively, the disk-shaped optical information medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein the optical information medium further includes a ring-shaped groove substantially concentric with the center holes of the substrates, formed on at least one of the first and second substrates at a position closer to the center holes with respect to the center of a clamp region for clamping the optical information medium, and a space between the first and second substrates of at least a half of the clamp region is filled with the radiation curable resin.

In one embodiment of the invention, an information signal surface is formed on a portion of the at least one substrate closer to an outer circumference of the substrate with respect to an outer rim of the groove on the substrate, and a reflection film is formed on the groove and the information signal surface.

Alternatively, the optical information medium of this invention includes a first substrate having a center hole, a second substrate having a center hole, and a radiation curable resin interposed between the first and second substrates to integrate the first and second substrates, wherein the radiation curable resin does not exist in a region adjacent to the center holes of the first and second substrates.

Alternatively, the disk-shaped optical informa-

tion medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein an outer circumference of at least one of the first and second substrates is tapered.

Alternatively, the disk-shaped optical information medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein the radiation curable resin has a weather-resistance pigment mixed therein.

Alternatively, the disk-shaped optical information medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein the radiation curable resin includes a resin of which color density varies with the level of the curing of the resin.

According to another aspect of this invention, a method for fabricating an optical information medium is provided. The method includes the steps of: forming a pair of substrates each having a center hole; placing one of the pair of substrates on the other substrate with a radiation curable resin interposed therebetween; and curing the radiation curable resin by irradiating the

resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond the pair of substrates together, wherein the step of forming a pair of substrates includes the step of forming a stopper for preventing the radiation curable resin from protruding into the center holes on at least one of the pair of substrates, and the step of placing one of the pair of substrates on the other substrate includes the step of filling at least a half of a clamp region of the optical information medium with the radiation curable resin.

In one embodiment of the invention, the step of placing one of the pair of substrates on the other substrate includes the steps of: applying the radiation curable resin to a portion of the substrate on which the stopper is formed closer to an outer circumference of the substrate with respect to the stopper to form a donut-shaped resin layer while the substrate is being rotated, placing the other substrate on the substrate with the stopper, and rotating both substrates integrally; and curing the radiation curable resin by irradiating the radiation curable resin with radioactive rays passing through at least one of the substrates.

In another embodiment of the invention, the step of placing one of the pair of substrates on the other substrate includes the step of: mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates.

In still another embodiment of the invention, the step of placing one of the pair of substrates on the other substrate includes the step of: mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates, and absorbing the radiation curable resin through the center holes of the pair of substrates while the pair of substrates are being rotated.

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In still another embodiment of the invention, in the step of curing the radiation curable resin, a transparent plate having an outer diameter smaller than an outer diameter of at least one of the pair of substrates is placed on the bonded pair of substrates and the radiation curable resin is irradiated with the radioactive rays passing through the transparent plate.

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Alternatively, the method for fabricating an optical information medium of this invention includes the steps of: forming a pair of substrates each having a center hole; placing one of the pair of substrates on the other substrate with a radiation curable resin interposed therebetween; and curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond the pair of substrates together, wherein the step of placing one of the pair of substrates on the other substrate includes the step of disposing the radiation curable resin so that the resin is away from the center holes of the substrates.

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In one embodiment of the invention, the step of forming a pair of substrates includes the step of forming

a stopper for preventing the radiation curable resin from protruding into the center holes on at least one of the pair of substrates.

5 In another embodiment of the invention, the step
of placing one of the pair of substrates on the other
substrate includes the steps of: applying the radiation
curable resin to a portion of the substrate on which the
stopper is formed closer to an outer circumference of the
substrate with respect to the stopper to form a donut-
shaped resin layer while the substrate is being rotated,
forming a layer of another radiation curable resin on a
portion of the substrate closer to an inner circumference
with respect to the stopper, placing the other substrate
on the substrate with the stopper, and rotating the both
substrates integrally; and curing the radiation curable
resin by irradiating the radiation curable resin with
radioactive rays passing through at least one of the pair
of substrates.

10 In still another embodiment of the invention, in
the step of curing the radiation curable resin, a
transparent plate is placed on the bonded pair of
substrates and the radiation curable resin is irradiated
15 with the radioactive rays passing through the transparent
plate.

20 In still another embodiment of the invention, the
another radiation curable resin is applied by use of a
25 roller.

30 Alternatively, the method for fabricating an
optical information medium of this invention includes the

steps of: forming a pair of substrates each having a center hole; placing one of the pair of substrates on the other substrate with a radiation curable resin interposed therebetween; and curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond the pair of substrates, wherein, in the step of forming a pair of substrates, an outer circumference of at least one of the pair of substrates is tapered.

In one embodiment, the step of placing one of the pair of substrates on the other substrate includes the step of: shaping the radiation curable resin at outer circumferences of the pair of substrates by use of a transfer roller having a shape corresponding to a shape of a recess formed by the tapered outer circumferences of the pair of substrates.

In another embodiment of the invention, the step of placing one of the pair of substrates on the other substrate includes the step of: mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates.

In still another embodiment of the invention, the step of placing one of the pair of substrates on the other substrate includes the step of: mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates, and absorbing the radiation curable resin

through the center holes of the pair of substrates while the pair of substrates are being rotated.

In still another embodiment of the invention, the
5 step of curing the radiation curable resin includes the step of placing on the bonded pair of substrates a transparent plate having another diameter smaller than an outer diameter of at least one of the pair of substrates and irradiating the radiation curable resin with the radioactive rays passing through the transparent plate.

Alternatively, the method for fabricating an optical information medium of this invention includes the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, wherein a sealant layer is formed of another radiation curable resin on a portion of one of the substrates closer to an inner circumference of the substrate, the viscosity of the another radiation curable resin when it is not cured being higher than that of the radiation curable resin for bonding formed on a portion of the substrate closer to an outer circumference of the substrate, and the radiation curable resins are cured by radioactive rays passing through the first or second substrate to bond the first and second substrates.

Alternatively, the method for fabricating an optical information medium of this invention includes the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, wherein a sealant layer is formed by printing a radiation curable

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resin on a portion of one of the substrates closer to an inner circumference of the substrate, and the radiation curable resins are cured by radioactive rays passing through the first or second substrate to bond the first and second substrates.

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Alternatively, the method for fabricating an optical information medium of this invention includes the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, wherein a sealant layer is formed of a hot melt adhesive on a portion of one of the substrates closer to an inner circumference of the substrate, the first and second substrates are pressed with the radiation curable resin and the sealant layer being interposed therebetween, and the radiation curable resin is cured by radioactive rays passing through the first or second substrate to bond the first and second substrates.

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Alternatively, the method for fabricating an optical information medium of this invention includes the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, wherein a portion of the radiation curable resin protruding into the center holes is removed before the radiation curable resin is cured.

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In one embodiment of the invention, the portion of the radiation curable resin protruding to the center holes is removed by use of a jig.

In another embodiment of the invention, the portion of the radiation curable resin protruding to the center holes is removed by absorbing through a suction port disposed on a boss of a spindle for rotating the substrates.

In still another embodiment of the invention, the portion of the radiation curable resin protruding to the center holes is removed by absorbing by a sponge disposed on a boss of a spindle for rotating the substrates.

Alternatively, the method for fabricating an optical information medium of this invention includes the steps of: placing one of a pair of substrates, each having a center hole, on the other substrate with a radiation curable resin interposed therebetween; and curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond together the pair of substrates, wherein a resin of which color density varies with the degree of the curing of the resin is used as the radiation curable resin, the color density of the resin is measured when the resin is irradiated with radioactive rays, and the curing of the resin is terminated when the resin obtains a predetermined color density.

Alternatively, the method for fabricating an optical information medium of this invention includes the step of bonding a first substrate and a second substrate with radiation curable resin interposed therebetween, wherein radioactive rays passing through the first substrate and radioactive rays passing through the second substrate radiate the radiation curable resin so as to

cure the radiation curable resin.

In one embodiment of the invention, at least one of radiation intensity and duration of the radioactive rays is adjusted according to a radioactive ray transmittance of the substrate through which the radioactive rays pass.

According to still another aspect of the invention, an apparatus for fabricating an optical information medium is provided. The apparatus includes: means for applying a radiation curable resin, while a first substrate having a stopper for preventing the radiation curable resin from protruding into a center hole is being rotated, to a portion of the first substrate closer to an outer circumference of the first substrate with respect to the stopper, to form a donut-shaped resin layer; means for placing a second substrate on the first substrate; means for rotating the first and second substrates integrally; and means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

In one embodiment of the invention, the apparatus further includes means for placing a transparent plate on the bonded substrates.

In another embodiment of the invention, the apparatus further includes means for applying another radiation curable resin to a portion of the substrate closer to an inner circumference of the substrate with respect to the stopper.

In still another embodiment of the invention, the means for applying another radiation curable resin includes any of brush means, roller means, and clean printing means.

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Alternatively, the apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween of this invention includes: means for applying a first radiation curable resin on a portion of the first substrate closer to an inner circumference of the first substrate and applying a second radiation curable resin having a viscosity lower than the first radiation curable resin to a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated; means for placing the second substrate on the first substrate;

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means for rotating the first and second substrates integrally; and means for irradiating the radiation curable resins with radioactive rays passing through at least one of the first and second substrates.

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Alternatively, the apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween of this invention includes: means for applying a portion of the radiation curable resin on a portion of the first or second substrate closer to an inner circumference of the first or second substrate; means for applying the remainder of the radiation curable

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resin on a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated; means for placing the second substrate on the first substrate; means for rotating the first and second substrates integrally; and means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

10 Alternatively, the apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween of this invention includes: means for applying a hot melt adhesive to a portion of the first or second substrate closer to an inner circumference of the first or second substrate; means for applying the radiation curable resin to a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated; means for placing the second substrate on the first substrate; means for rotating the first and second substrates integrally; and means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

15 Alternatively, the apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween of this invention includes: a table for integrally rotating the first and second substrates with the radiation curable resin before being cured interposed

therebetween; and means for absorbing the radiation curable resin interposed between the first and second substrates through the center holes of the first and second substrates.

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Alternatively, the apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween of this invention includes: means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates; and means for measuring a color density of the radiation curable resin.

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In one embodiment of the invention, in the step of curing the radiation curable resin, the radioactive rays are reflected near the outer circumferences of the substrates placed on each other to irradiate the outer circumferences of the substrates.

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In another embodiment of the invention, the radioactive rays are reflected by a mirror of a truncated cone shape disposed to surround the outer circumferences of the substrates.

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In still another embodiment of the invention, the apparatus further includes means for irradiating the outer circumferences of the substrate placed on each other with the radioactive rays.

Thus, the invention described herein makes possible the advantages of (1) providing a thin optical

information medium with good appearance and high mechanical strength without protrusion of a radiation curable resin to a center hole of the medium, (2) providing a method for fabricating such an optical information medium, and (3) providing an apparatus for fabricating such an optical information medium.

These and other advantages of the present invention will become apparent to those skilled in the art upon reading and understanding the following detailed description with reference to the accompanying figures.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a sectional view of a conventional optical disk.

Figures 2A to 2D are perspective views showing a conventional fabrication process of the optical disk of Figure 1.

Figure 3 is a partial perspective sectional view of an optical disk of Example 1 according to the present invention.

Figure 4 is a partial sectional view of an injection molding apparatus used for fabricating substrates for the optical disk of Example 1 according to the present invention.

Figures 5A to 5D are perspective views showing a fabrication process of the optical disk of Example 1 according to the present invention.

Figure 6 is a partial sectional view of an apparatus used for fabricating the optical disk of Example 1 according to the present invention.

5 Figure 7 is a sectional view showing a step for fabricating the optical disk of Example 1 according to the present invention.

10 Figure 8 is a perspective view showing a step for fabricating an optical disk of Example 2 according to the present invention.

15 Figure 9 is a partial perspective sectional view of the optical disk of Example 2 according to the present invention.

20 Figure 10 is a partial perspective sectional view of an optical disk of Example 3 according to the present invention.

25 Figure 11 is another injection molding apparatus used for fabricating a substrate of the optical disk of Example 3 according to the present invention.

30 Figure 12 is yet another injection molding apparatus used for fabricating a substrate of the optical disk of Example 3 according to the present invention.

35 Figures 13A to 13D are perspective views showing a fabrication process of the optical disk of Example 3 according to the present invention.

Figure 14 is partial perspective sectional view

showing a step for fabricating an optical disk of Example 4 according to the present invention.

5 Figure 15 is a sectional view showing a step for
fabricating an optical disk of Example 5 according to the
present invention.

10 Figure 16 is a partial perspective sectional view
of an optical disk of Example 6 according to the present
invention.

15 Figures 17A to 17D are perspective views showing
a fabrication process of the optical disk of Example 6
according to the present invention.

20 Figure 18 is a perspective view showing a step
for fabricating an optical disk of Example 8 according to
the present invention.

25 Figure 19 is a perspective view showing a step
for fabricating an optical disk of Example 9 according to
the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

30 An optical information medium (optical disk) of
the present invention is formed by bonding together a
pair of substrates, each having a center hole, by use of
a radiation curable resin. The optical disk of the
present invention further includes a stopper for prevent-
ing the radiation curable resin from protruding into the
center hole. The resin spreads in a space between the
substrates covering at least a half of a clamp region for

securing the optical disk to a turntable. The stopper is preferably a concave or convex portion formed on each of the substrates.

5 When a groove which is substantially concentric with the center hole is formed as the stopper on each substrate at a position closer to the inner circumference (closer to the center hole) with respect to the clamp region, the substrates are bonded together in the following manner. While one of the substrates is being rotated at low speed, a radiation curable resin is applied to a portion of the substrate closer to the outer circumference with respect to the groove, forming a donut-shaped resin layer. The other substrate is placed on the substrate with the resin therebetween. The two substrates are then rotated together at high speed, to allow the radiation curable resin to spread substantially uniformly in the space between the two substrates from the grooves to the outer circumferences of the substrates. Then, the radioactive rays are radiated to cure the radiation curable resin and thus to bond the two substrates integrally.

25 When a groove is formed at a position closer to the outer circumference with respect to the clamp region, the substrates are bonded together in the following manner. While one of the substrates is being rotated at low speed, a radiation curable resin is applied to a portion of the substrate closer to the outer circumference with respect to the groove, forming a donut-shaped resin layer. At the same time, the radiation curable resin is also applied to a portion of the substrate closer to the inner circumference with respect to the

groove but away from the center hole. The other substrate is placed on the substrate with the resin therebetween. The two substrates are then rotated together at high speed, to allow the radiation curable resin to spread substantially uniformly in the space between the two substrates covering the portion closer to the outer circumferences with respect to the grooves and the portion closer to the inner circumferences with respect to the grooves but away from the center hole.

5 Then, the radioactive rays are radiated to cure the radiation curable resin and thus to bond the two substrates integrally.

10 In the former case where the groove is formed at a position closer to the inner circumference with respect to the clamp region, the groove serves as a reservoir for excessive resin produced when the resin spreads in the space between the two substrates. This prevents the resin from spreading beyond the groove to the portion closer to the inner circumference and thus the resin from protruding into the center hole. Since the resin spreads in the entire clamp region, the resultant disk has high strength.

15 In the latter case where the groove is formed at a position closer to the outer circumference with respect to the clamp region, a thin radiation curable resin layer is formed on a portion closer to the inner circumference with respect to the groove, besides the resin layer on a portion closer to the outer circumference with respect to the groove, before the two substrates are bonded together. Thus, the clamp region is supplied with a sufficient amount of resin. Since the resin layer on the inner

circumference portion is formed thin and away from the center hole, the resin is prevented from protruding into the center hole.

5 (Example 1)

A first example of the optical information medium according to the present invention will be described.

10 Figure 3 shows an optical disk of Example 1. The optical disk includes disk-shaped first and second substrates 1 and 4 (thickness: 0.6 mm each) bonded together integrally with a radiation curable resin 7. The first substrate 1 has a first information signal surface 2, on which a first reflection film 3 (thickness: 0.03 μm to 0.2 μm) made of aluminum as a main component is formed. The second substrate 4 has a second information signal surface 5, on which a second reflection film 6 is formed. The first and second substrates 1 and 4 are bonded together with the information signal surfaces 2 and 5 facing each other with the radiation curable resin 7 interposing.

25 Grooves and pits are formed on the information signal surfaces 2 and 5 of the substrates 1 and 4. When the disk is of a rewritable type, a recording film (not shown) is formed on the information signal surface 2 or 5 of at least one of the substrates 1 and 4.

30 In general, an optical disk has a clamp region (indicated by the arrow in Figure 3) for securing the optical disk to a turntable of a recording/reproduction apparatus. The clamp region, which is of a donut shape, occupies the region of the disk ranging from 11 mm to

16.5 mm from the center of the disk, in the case of DVDs. In other words, the clamp region is a ring-shaped region with an inner diameter of 22 mm and an outer diameter of 33 mm.

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In Example 1, grooves 8 and 9 which are substantially concentric with the center hole are formed on the first and second substrates 1 and 4, respectively. The function of the grooves 8 and 9 will be described later in detail. In Example 1, the grooves 8 and 9 have a depth of 0.3 mm or less and a width of 3 mm or less, and are formed at a position closer to the inner circumference (closer to the disk center) with respect to the outer rim of the clamp region. The depth of the grooves is preferably equal to or less than a half the thickness of each substrate.

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If the grooves 8 and 9 are formed at a position closer to the outer circumference with respect to the outer rim of the clamp region, the clamp region is not supplied with a sufficient amount of resin. In Example 1 where the radiation curable resin is used for bonding the substrates together, the gap between the substrates is about 50 μm , five times as large as that when a hot melt adhesive is used (about 10 μm). The Inventors have found from experiments that, with the large gap between the substrates, if the clamp region is not supplied with a sufficient amount of resin, the clamp region fails in stably securing the optical disk to a turntable.

The Inventors have further found that, in order to obtain stable clamping, it is necessary to supply the radiation curable resin to at least a half of the clamp

region. Specifically, in the case of DVDs, the grooves 8 and 9 need to be positioned so that the distance between the groove center and the disk center is 13.75 mm (= 11/2 + 16.5/2) or less. When the grooves 8 and 9 with a width of 3 mm are formed so that the groove center is positioned at a distance of 12.5 mm or less from the disk center, substantially the entire clamp region will be supplied with the radiation curable resin. Accordingly, the grooves 8 and 9 are preferably formed so that the groove center is positioned at a distance of 12.5 mm or less from the disk center.

The insides of the grooves 8 and 9 are not necessarily filled with the radiation curable resin 7. Accordingly, the inner end of the radiation curable resin 7 is positioned at the outer rims of the grooves 8 and 9 or at the inner rims of the grooves including the inside of the grooves. Figure 3 shows the latter case as an example.

The grooves 8 and 9 can be formed by use of a jig for a stamper having a pattern of information signals when the substrates 1 and 4 are formed by injection molding using the stamper. The size and shape of the grooves 8 and 9 can be controlled by adjusting the size and shape of the jig. The shape of the grooves 8 and 9 is not limited to that shown in Figure 3. Only one groove, instead of the grooves 8 and 9, can be formed on either one of the substrates 1 and 4. Alternatively, a plurality of grooves can be formed close to one another on one substrate.

Figure 4 shows the injection molding of the

substrate. A donut-shaped stamper 12 having a center hole is attached to one surface of a cylindrical movable mold 11 with a jig 13. A ring-shaped convex portion 13a is formed on an end of the jig 13 and presses the stamper 12 against the movable mold 11. The substrate 1 or 4 is formed by injecting resin into a cavity 15 formed between the movable mold 11 and a fixed mold 14 from right as seen from the figure and then cooling the resin. At this formation of the substrate, the groove 8 or 9 is formed on the substrate 1 or 4 due to the convex portion 13a of the jig 13 for the stamper 12. Thus, the size and shape of the grooves 8 and 9 can be controlled by adjusting the size and shape of the convex portion 13a of the jig 13.

Next, referring to Figures 5A to 5D, a method for fabricating the optical disk according to the present invention will be described.

First, the first substrate 1 with the first information signal surface 2 is formed by injection molding and the like. The first reflection film 3 is formed on the first information signal surface 2 by sputtering and vapor deposition. The second substrate 4 with the second information signal surface 5 is formed by injection molding and the like. The second reflection film 6 is formed on the second information signal surface 5 by sputtering and vapor deposition. The reflection films 3 and 6 are made of metal including aluminum as a main component.

While the first substrate 1 is rotated at low speed (20 to 120 rpm), the radiation curable resin 7 is

applied to a portion of the substrate 1 closer to the outer circumference with respect to the groove 8 to form a donut-shaped resin layer (Figure 5A). The second substrate 4 is placed on the first substrate 1 so that the second reflection layer 6 faces the radiation curable resin 7 (Figure 5B). The radiation curable resin 7 spreads in the space between the substrates 1 and 4. At this time, the grooves 8 and 9 serve as reservoirs for excessive resin, preventing the resin from spreading beyond the grooves toward the inner circumference and thus the resin from protruding into the center hole. In place of the continuous ring-shaped grooves, a plurality of concave portions can be arranged at positions close to one another and apart from the disk center by an equal distance.

The substrates 1 and 4 are rotated together at high speed (300 to 5000 rpm), to allow the radiation curable resin to spread substantially uniformly in the space between the two substrates covering the portion from the grooves to the outer circumferences (Figure 5C). In Example 1, this step is performed using an apparatus shown in Figure 6. The apparatus includes a table 111 for rotating an optical disk, a boss 112 having suction ports 113, and a suction pump 114 connected to the suction ports 113. Since the radiation curable resin has fluidity before being cured, the resin can be absorbed by the suction pump 114 via the suction ports 113 formed on the boss 112 on the table 111. In this way, the radiation curable resin can spread uniformly in the space between the substrates. In this example, the number of the suction ports 113 is 2 or more, each having an inner diameter of 1 mm or more. The suction force can be

experimentally optimized in accordance with the viscosity of the resin, the rotation speed and duration of the table 111 and the like.

5 The outer diameter of the table 111 is preferably smaller than that of the first and second substrates 1 and 4, so as to prevent part of the radiation curable resin protruding from the outer circumferences of the rotating substrates from attaching to the table 111. In
10 Example 1, a radius Rt of the table 111 is set at 59 mm or less, which is smaller than a radius Rs of the substrates (60 mm) by 1 mm or more. If the radius Rt of the table 111 is too small, the table 111 fails to support the optical disk stably. Thus, the radius Rt of the table 111 is preferably 70% or more of the radius Rs of the optical disk.
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20 As described above, a centripetal force is provided by absorbing the radiation curable resin at the rotation of the substrates. This prevents a large amount of resin from moving to the outer circumference of the optical disk. Further, any resin which may protrude from the outer circumference of the optical disk can be prevented from attaching to the table and polluting the
25 disk by making the size of the table smaller than that of the optical disk.
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 By absorbing the resin through the center hole of the optical disk, it is ensured that the resin remains in the clamp region during the high-speed rotation, and the resin can spread uniformly. Further, since excessive resin protruding into the center hole of the optical disk is pumped via the suction ports 113 and removed, the

resultant optical disk has good appearance.

Sponges can be disposed on the boss 112 in place of the suction ports 113 for absorbing the radiation curable resin 7. In this case, similarly, excessive resin protruding into the center hole of the optical disk can be removed.

Thereafter, radioactive rays are radiated to the radiation curable resin through the second substrate 4 and the second reflection film 6 to cure the resin, so as to bond the substrates 1 and 4 integrally (Figure 5D).

Ultraviolet (UV) rays can be used as the radioactive rays, and a UV curable resin as the radiation curable resin. The reflection film made of metal including aluminum as a main component allows a small amount of UV rays to transmit therethrough (transmittance: 1% or less) which is large enough to cure the UV curable resin if the thickness of the reflection film is 0.1 μm or less.

Alternatively, a protection film made of the radiation curable resin can be formed on the reflection film on the first or second substrate, before the above process including the application of the radiation curable resin for bonding, the placement of the other substrate on the resin, and the radiation of radioactive rays.

Heat is generally generated at the curing of the radiation curable resin by radioactive ray radiation. The substrates may sometimes be warped a little by this

heat. To prevent this trouble, a transparent plate can be placed on the second substrate during irradiation. The resin is then cured with radioactive rays passing through the transparent plate, the second substrate, and the second reflection film. As a result, the substrates are prevented from warping, and a disk with a negligibly small tilt can be fabricated. Figure 7 shows this alternative step, where a transparent plate 10 presses the integrated first and second substrates 1 and 4. The transparent plate can be made of glass.

In Example 1, the substrates both having information signals recorded thereon were bonded together. Alternatively, one of the substrates can be a dummy substrate where information signals have not been recorded.

Also, in the case of a double-layer disk where a semi-transparent film is formed on the information signal surface of the substrate 4, the radiation curable resin can be irradiated with radioactive rays through the semi-transparent substrate 4. Thus, the substrates can be easily bonded together.

The grooves 8 and 9 on the substrates prevent excessive resin from spreading beyond the grooves to the inner circumference portions. However, the resin is not necessarily accumulated in the grooves uniformly. If the resin in the grooves 8 and 9 is not uniform and air portions and resin portions are formed in a mixed condition in the grooves, the appearance of the resultant disk will be poor. This is why the reflection films are also formed on the grooves 8 and 9 as shown in Figure 3. By

forming the reflection films, the grooves 8 and 9 become invisible from outside and the good appearance can be maintained.

5 (Example 2)

In example 2, an optical disk where a groove is formed on each substrate at a position closer to the outer circumference with respect to the clamp region will be described with reference to Figures 8 and 9.

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As described above, in order to prevent the resin from protruding to the center hole of the substrates, the resin should be applied to a portion of a substrate closer to the outer circumference with respect to the outer rim of the groove. This means, however, that no resin is applied to the clamp region and therefore the resultant disk is not secured to a turntable. In Example 2, in order to prevent this trouble, the radiation curable resin is also applied to a portion of the substrate closer to the inner circumference with respect to the groove to form a resin layer 16, separately, before the application of the radiation curable resin to a portion closer to the outer circumference of the groove 8. The resin layer 16 can be formed by use of a roller 17 with a width of about 5 to 10 mm as shown in Figure 8. As in Example 1, the resin layer 16 is preferably positioned away from the center hole so as to prevent the resin from protruding into the center hole of the substrate.

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Figure 9 shows the optical disk of Example 2. The same components are denoted by the same reference numerals as those in Figure 3. The grooves of the

substrates are formed at a position closer to the outer circumference with respect to the outer rim of the clamp region (indicated by the arrow in Figure 9). The resin layer 16 is formed on a portion of the substrate closer to the inner circumference with respect to the grooves, separately from the application of the radiation curable resin 7 to a portion of the substrate closer to the outer circumference with respect to the grooves. As a result, though the resin may not be so uniform, a sufficient amount of resin can be supplied in the clamp region and cured.

Both the optical disks of Examples 1 and 2 are of a double-sided reproduction type. In the case of an optical disk of a single-sided reproduction type, the substrate 4 can be a transparent dummy plate having neither an information signal surface nor a reflection film. In this case, the radiation curable resin is irradiated with radioactive rays through the transparent dummy plate. This makes it possible to cure the resin in a shorter time than the case of the optical disk of the double-sided reproduction type and thus shorten the production time.

Also, in the case of a double-layer disk where a semi-transparent film is formed on the information signal surface of the substrate 4, the radiation curable resin can be irradiated with radioactive rays through the semi-transparent substrate 4. Thus, the substrates can be easily bonded together.

(Example 3)

A third example of the optical information medium

according to the present invention will be described with reference to Figures 10, 11, 12, and 13A to 13D.

As shown in Figure 10, a first substrate 1 has a first information signal surface 2, on which a first reflection film 3 made of metal and the like including aluminum as a main component is formed. A second substrate 4 has a second information signal surface 5, on which a second reflection film 6 is formed. The substrates 1 and 4 have a protrusion 40 (height: 0.01 to 0.2 mm, width: 0.1 to 2 mm) and a groove 50 (depth: 0.05 to 0.3 mm, width: 0.3 to 3 mm), respectively. A radiation curable resin 7 spreads in the space between the substrates 1 and 4 from the outer rims of the protrusion 40 and the groove 50 to the outer circumferences of the substrates or from the inner rims of the protrusion 40 and the groove 50 to the outer circumferences of the substrates including the protrusion 40 and the groove 50. Figure 10 shows the latter case as an example.

The region indicated by the arrow in Figure 10 is the clamp region for securing the optical disk to a turntable of a reproduction apparatus. In the clamp region, the radiation curable resin needs to be cured sufficiently, and to attain this, the protrusion 40 and the groove 50 need to be located closer to the center hole with respect to the center of the clamp region. Further, the two substrates need to be aligned with respect to the center of the center hole to avoid decentering and cured sufficiently.

The protrusion 40 and the groove 50 of Example 3

serve as the stopper, as the grooves 8 and 9 shown in Figure 3, for preventing the radiation curable resin from protruding into the center hole. The groove 50 on the substrate 4 may be omitted. In this case, only the protrusion 40 serves as the stopper for the radiation curable resin. Alternatively, another protrusion can be formed on the substrate 4 in place of the groove 50. In this case, the protrusion on the substrate 4 needs to be located so as not to collide with the protrusion 40 of the substrate 1. The protrusion 40 and the groove 50 of Example 3 are of a continuous ring shape surrounding the center holes of the substrates. However, the protrusion 40 and the groove 50 do not necessarily have to be continuous. For example, a plurality of protrusions can be arranged at positions apart from the disk center by an equal distance. Alternatively, a plurality of protrusions can be arranged on both of the substrates so that the protrusions on one substrate can engage with the protrusions on the other substrate when the two substrates are bonded together.

Next, a method for fabricating the optical disk shown in Figure 10 will be described with reference to Figures 11, 12, and 13A to 13D.

The first substrate 1 having the first information signal surface 2 is formed with a transparent resin such as polycarbonate by injection molding and the like. The first reflection film 3 is formed on the first information signal surface 2 by sputtering and vapor deposition. The second substrate 4 having the second information signal surface 5 is formed by injection molding and the like, and the second reflection film 6 is

formed on the second information signal surface 5 by sputtering and vapor deposition. The first and second reflection films 3 and 6 are made of metal including aluminum as a main component.

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The protrusion 40 which is substantially concentric with the center hole is formed on the first substrate 1, while the groove 50 is formed on the second substrate 4 so as to face the protrusion 40 of the first substrate 1 when the substrates 1 and 4 are bonded together. The protrusion 40 and the groove 50 can be formed by use of a jig for a stamper having a pattern of information signals when the substrates 1 and 4 are formed by injection molding using the stamper. Figures 11 and 12 show the injection molding of the substrate. A stamper 12 is attached to one surface of a movable mold 11. The substrate is formed by injecting a resin into a cavity 15 formed between the movable mold 11 and a fixed mold 14 and then cooling the resin. At this formation of the substrate, the groove 50 is formed on the substrate 4 by forming a convex portion 13a on a jig 13 as shown in Figure 11, or the protrusion 40 is formed on the substrate 1 by forming a concave portion 13b on the jig 13 as shown in Figure 12.

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As shown in Figure 13A, while the substrate 1 is being rotated at low speed, the radiation curable resin 7 is applied to a portion of the substrate 1 closer to the outer circumference with respect to the protrusion 40 to form a donut- or spiral-shaped resin layer. Then, as shown in Figure 13B, the second substrate 4 is placed on the first substrate 1 so that the second reflection film 6 faces the radiation curable resin 7. As shown in

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Figure 13C, the radiation curable resin 7 spreads in the space between the substrates 1 and 4, while the substrates are being rotated at high speed. At this time, the spread of the resin is blocked by the protrusion 40, preventing the resin from spreading beyond the protrusion 40 toward the center hole. Thus, the radiation curable resin 7 spreads substantially uniformly in the space between the substrates 1 and 4 from the protrusion 40 to the outer circumferences of the substrates.

Thereafter, as shown in Figure 13D, radioactive rays are radiated to the radiation curable resin via the second substrate 4 and the second reflection film 6 to cure the resin, so as to bond the substrates 1 and 4 integrally.

UV rays can be used as the radioactive rays, and a UV curable resin as the radiation curable resin. The reflection film made of metal including aluminum as a main component allows a small amount of UV rays to transmit therethrough (transmittance: 1% or less) so as to cure the UV curable resin if the thickness of the reflection film is 0.1 μm or less.

Alternatively, a protection film made of the radiation curable resin can be formed on the reflection film on the first or second substrate, before the process shown in Figures 3A to 3D including the application of the radiation curable resin for bonding, the placement of the other substrate on the resin, and the radiation of radioactive rays.

(Example 4)

In Example 4, a method for shaping the outer end of the radiation curable resin at the outer circumferences of the substrates will be described with reference to Figure 14.

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An optical disk having two substrates bonded together needs to have mechanical strength large enough to be durable against drop, shock, and the like. Conventionally, however, the following problem arises: The radiation curable resin used for bonding the two substrates tends to spread only to the signal recording portions, not reaching the outer circumferences of the substrates. Even if the resin reaches the outer circumferences, it is difficult to obtain uniform spread of the resin. If the resin with non-uniform spread is cured by being irradiated with radioactive rays, the substrates tend to easily separate from each other at the end rims thereof due to drop and shock, lowering the mechanical strength of the resultant disk. In order to solve this problem, an outer diameter ϕ_a of the bonding surface of each of the first and second substrates 1 and 4 is made slightly smaller than an outer diameter ϕ_b of the other surface opposite to the bonding surface, forming a tapered end at the outer circumference of each of the substrates 1 and 4 and thus forming tilt faces 18 and 19, respectively. As a result, a recess is formed around the outer circumference of the resultant optical disk. The recess is filled with the radiation curable resin. The tapered end (tilt face) can be formed only on one of the substrates 1 and 4. The tapered ends can be of any shape as far as the relationship $\phi_a \leq \phi_b$ is satisfied.

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On the tilt faces of the substrates is accumulated only excessive resin swept off from the space between the substrates 1 and 4 by high-speed rotation of the substrates via a rotational table (not shown) disposed below the substrates. The resin accumulated on the tilt faces is therefore not uniform. In this example, a rotational transfer roller 20 having a shape and size equal to those of the recess formed by bonding the first and second substrates 1 and 4 is used. The size of the roller 20 can be slightly smaller than that of the recess. The roller 20 is driven in the directions shown in Figure 14 so as to abut against the substrates. When the roller 20 is moved toward the substrates, the rotational table is switched to low speed to allow the roller 20 to abut against the substrates and rotate in a direction reverse to the rotational direction of the rotational table. Alternatively, the roller can be fixed. The radiation curable resin is extracted from an extraction nozzle 21 at an appropriate time so that the roller 20 can always transfer the resin to the substrates. Thus, the shaping of the outer circumferences of the substrates can be maintained. By curing the resin by the radiation of radioactive rays under this state, an optical disk with high mechanical strength can be fabricated.

(Example 5)

In Example 5, a method for curing resin will be described with reference to Figure 15. Since radioactive rays are linear, the radiation curable resin at the circumferences of the substrates may not be irradiated sufficiently enough to be cured completely within a predetermined irradiation time. In order to solve this

problem, a reflector 24 is disposed at a position to enable the circumferences of the substrates to be irradiated while a rotational table 22 is rotated at low speed. With this structure, the radiation curable resin 7 in the space between the substrates as well as at the circumferences of the substrates can be uniformly and stably cured.

Alternatively, a mirror of a truncated cone shape can be disposed to surround the circumferences of the substrates. In this case, it is not necessary to rotate the table.

(Example 6)

An optical information medium of Example 6 will be described with reference to Figure 16. First and second substrates 1 and 4 have first and second information signal surfaces 2 and 5, on which first and second reflection films 3 and 6 are formed, respectively. A radiation curable resins 70 and 90 are interposed between the first and second substrates 1 and 4. The resin 90 serves as a sealant preventing the resin from protruding into the center hole of the substrates.

Referring to Figures 17A to 17D, a method for fabricating such an optical disk for double-sided reproduction according to the present invention will be described.

The first substrate 1 having the first information signal surface 2 and the second substrate 4 having the second information signal surface 5 are formed with a transparent resin such as polycarbonate by injection

molding and the like. The first and second reflection films 3 and 6 are formed on the information signal surfaces 2 and 5, respectively, by sputtering and vapor deposition. The reflection films 3 and 6 are made of metal including aluminum as a main component, for example.

While the first substrate 1 is being rotated at low speed, the radiation curable resin 70 which serves as a major adhesive for the bonding of the substrates is applied to a portion of the first substrate 1 closer to the outer circumference to form a donut-shaped resin layer. At the same time, the radiation curable resin 90 which has a viscosity higher than the radiation curable resin 70 is applied to a portion of the first substrate 1 closer to the inner circumference to form a donut-shaped resin layer (Figure 17A). The second substrate 4 is then placed on the first substrate 1 with the second information signal surface 5 facing the radiation curable resins 70 and 90 (Figure 17B).

If the radiation curable resin 90 is not formed as described above, the radiation curable resin 70 will spread in the space between the substrates 1 and 4 when the substrate 4 is placed on the substrate 1, protruding into the center hole of the substrates 1 and 4. When the resin is cured before it spreads to the inner circumferences of the substrates, a sufficient amount of resin is not supplied to the inner circumference portion, resulting in obtaining a disk with low strength.

The radiation curable resin 90 which has high viscosity does not spread so widely and thus does not

protrude into the center hole of the substrates 1 and 4. Though the radiation curable resin 70 spreads, it is prevented from protruding into the center hole by being blocked by the radiation curable resin 90.

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Thereafter, the substrates 1 and 4 are rotated together at high speed so as to allow the radiation curable resin to spread substantially uniformly in the space between the substrates 1 and 4 (Figure 17C). Radioactive rays are radiated to the radiation curable resins via the second substrate 4 and the second reflection film 6, bonding the two substrates integrally (Figure 17D).

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In general, UV rays are used as the radioactive rays, and a UV curable resin as the radiation curable resin. The metal reflection film including aluminum as a main component allows a small amount of UV rays to transmit therethrough so as to cure the UV curable resin if the thickness of the reflection film is 0.1 μm or less.

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A protection film made of the radiation curable resin can be formed on the reflection film on the first or second substrate, before the process shown in Figures 17A to 17D including the application of the radiation curable resin for bonding, the placement of the other substrate on the resin, and the radiation of radioactive rays. Forming the protection film requires an additional step. However, by protecting the reflection film with the protection film, the selection of the radiation curable resin for bonding becomes less restrictive, and the weather resistance of the reflection film

can be enhanced.

In Example 6, the radiation curable resin 90 as the sealant layer was formed by spin coating. Instead, the sealant layer 90 can be formed by printing. Printing is easier than spin coating for the application of a radiation curable resin with a viscosity higher than a certain level.

A hot melt adhesive having a viscosity higher than the radiation curable resin 70 can also be used as the sealant layer 90. The hot melt adhesive can be applied by use of a roll coater, for example.

In Example 6, the substrates each having the information signal surface were bonded. Instead, one of the substrates can be a dummy substrate having no information signals recorded thereon.

Also, in the case of a double-layer disk where a semi-transparent film is formed on the information signal surface of the substrate 4, the radiation curable resin can be irradiated with radioactive rays through the semi-transparent substrate 4. Thus, the substrates can be easily bonded together.

Thus, the optical disk of Example 6 has a sealant layer formed on a portion of the substrate closer to the inner circumference. Accordingly, when the radiation curable resin applied to the substrate spreads toward the inner circumference, it will not protrude to the center hole by being blocked by the sealant layer. As a result, troubles such as decentering do not occur when the disk

is mounted on a turntable of a player. Further, since a sufficient amount of resin is supplied to the inner circumference of the disk, the bonding strength can be increased.

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(Example 7)

An optical information medium of Example 7 will be described.

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A radiation curable resin layer formed between substrates of the optical disk of Example 7 contains a weather-resistance pigment. Herein, UV rays are used as the radioactive rays and a UV curable resin is used as the radiation curable resin.

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In conventional optical disks, UV curable resin becomes decolorized with time, consequently deteriorating the appearance of the bonded substrates.

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By mixing a weather-resistance pigment in the UV curable resin, the decoloration of the UV curable resin becomes less eminent, preventing the appearance of the bonded substrates from being deteriorated with time.

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The optical disk of Example 7 using the radiation curable resin having a weather-resistance pigment mixed therein is fabricated as follows.

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A UV curable resin in which a weather-resistance pigment is mixed uniformly is prepared. Using this resin as the radiation curable resin 7, the conventional process shown in Figures 2A to 2D is followed.

In Example 7, the substrates each having the information signal surface were bonded. Instead, one of the substrates can be a dummy substrate having no information signals recorded thereon.

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The fabrication method of this example can also be applied to the fabrication of optical disks of other examples according to the present invention.

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(Example 8)

An optical information medium of Example 8 will be described with reference to Figure 18.

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In the optical disk of Example 8, a radiation curable resin of which color density varies with the level of the curing thereof is used as the resin for bonding substrates. Herein, a UV curable resin is used as the radiation curable resin and UV rays are radiated to the resin.

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Conventionally, there is no way to determine the degree of the curing of the UV curable resin, except for breaking the bonded substrates and conduct a destructive test, directly measuring the hardness of the UV curable resin. Thus, 100% inspection is not possible, and it is difficult to obtain a uniform degree of curing for all disks fabricated.

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According to the optical disk of Example 8 having a radiation curable resin of which color density varies with the degree of curing, the degree of the curing of the radiation curable resin can be determined by the color density of the resin in a non-destructive manner.

Thus, a uniform degree of curing for all disks fabricated can be obtained by terminating the curing of the resin when the resin obtains a predetermined color density.

5 As the UV curable resin with a color density varying with the degree of curing, SD-1700 manufactured by Dainippon Ink & Chemicals, Inc., for example, can be used.

10 A method for fabricating the optical disk of Example 8 will be described.

15 A UV curable resin having a color density varying with the degree of curing is prepared. Using this resin as the radiation curable resin 7, a process similar to the conventional process shown in Figures 2A to 2D is followed. That is, the UV curable resin is applied to the first substrate 1. The second substrate 4 is placed on the first substrate 1 with the second reflection film 6 facing the UV curable resin. The substrates 1 and 4 are rotated together with high speed so as to allow the UV curable resin to spread in the space between the substrates 1 and 4.

25 In Example 8, an apparatus including a UV source 35 and a sensor 36 for detecting the color density of the UV curable resin as shown in Figure 18 is used at the curing of the UV curable resin, instead of the conventional step shown in Figure 2D.

30 When the UV curable resin is irradiated with UV rays from the UV source 35 through the substrate 4, the color density of the UV curable resin is detected with

the sensor 36. The radiation of UV rays is discontinued immediately after the color density of the UV curable resin reaches a predetermined color density corresponding to the complete curing of the UV curable resin which has been previously determined. Thus, it is ensured that the UV curable resin has been completely cured. A color-difference meter, for example, can be used as the sensor 36.

Thus, this example makes it possible to confirm the complete curing of the UV curable resin without conducting a destructive test, conduct 100% inspection of products, and obtain a uniform degree of curing for all disks fabricated.

In Example 8, the substrates each having the information signal surface were bonded. Instead, one of the bonded substrates can be a dummy substrate having no information signals recorded thereon.

(Example 9)

A method for fabricating an optical information medium of Example 9 will be described with reference to Figure 19. Herein, a UV curable resin is used as the radiation curable resin and UV rays are used to irradiate the resin.

Curing of the UV curable resin starts from the portion closest to a light source. Accordingly, the outer circumferences of bonded substrates tend to warp toward a light source.

In the method of Example 9, a process similar to

the conventional process shown in Figures 2A to 2D is followed. That is, the UV curable resin is applied to the first substrate 1. The second substrate 4 is placed on the first substrate 1 with the second reflection film 6 facing the UV curable resin. The substrates 1 and 4 are rotated together with high speed so as to allow the UV curable resin to spread in the space between the substrates 1 and 4.

In Example 9, an apparatus including two UV sources 35 and 37 as shown in Figure 19 is used at the curing of the UV curable resin, instead of the conventional step shown in Figure 2D. The UV source 35 emits UV rays to irradiate the UV curable resin 7 through the substrate 4 and cure the resin from the side of the substrate 4, while the UV source 37 emits UV rays to irradiate the UV curable resin 7 through the substrate 1 and cure the resin from the side of the substrate 1.

At the curing of the UV curable resin 7, the UV curable sources 35 and 37 are operated alternately each for a predetermined time period or simultaneously. Thus, the UV curable resin 7 is substantially uniformly cured and contracted from both sides of the substrates 1 and 4, preventing the substrates 1 and 4 from warping due to non-uniform curing and contraction of the UV curable resin 7.

As a result, an optical disk having the first and second substrates 1 and 4 bonded integrally with reduced warping can be obtained.

In the case where the substrates 1 and 4 have

different UV transmittances, the intensity or duration of the UV radiation by the UV sources 35 and 37 can be adjusted to supply different amounts of light to the UV curable resin 7 between from the side of the substrate 1 and from the side of the substrate 4 and thus to obtain the same effect as that described above.

The same effect can also be obtained by using only the UV source 35 and turning over the substrates 1 and 4 with the UV curable resin 7 therebetween or moving the UV source 35 to the opposite position where the UV source 37 is otherwise located.

A dummy substrate having neither an information signal surface nor a reflection film can be used in place of the substrate 1 or 4 to obtain the same effect as described above.

Thus, according to the present invention, an optical disk having thin substrates bonded together where no protrusion of resin into the center holes of the substrates is observed and good appearance is maintained is provided. A method and an apparatus for fabricating such an optical disk can also be provided.

According to an optical disk of the present invention, a stopper is provided for preventing a radiation curable resin from protruding into the center holes of the substrates. Also, at least a half of the clamp region of the optical disk is supplied with the resin. Thus, the resin is prevented from protruding into the center holes of the substrates, and the clamp region has high strength, providing stable clamping of the disk.

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According to another optical disk of the present invention, a sealant layer is formed near the inner circumference of the substrate. Thus, the radiation curable resin spreading toward the center hole is prevented from protruding into the center hole. As a result, troubles such as decentering at mounting the optical disk on a turntable of a player can be avoided.

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The radiation curable resin before curing can be absorbed through suction ports disposed at the center hole of the substrates, so as to suppress the movement of the resin to the outer circumferences of the substrates and remove resin protruding into the center hole. Any resin protruding from the outer circumferences of the substrates is prevented from attaching to a rotational table for rotating the substrates by making the outer diameter of the rotational table smaller than that of the substrates. Protruding resin may be removed by a jig and the like before being cured. Thus, an optical disk with reduced decentering is obtained.

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A weather-resistance pigment can be mixed in the radiation curable resin. This makes decoloration of the radiation curable resin less visible and prevents the good appearance of the bonded substrates from deteriorating with time.

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A radiation curable resin of which color density varies with the degree of the curing thereof can be used. This makes it possible to measure the degree of the curing of the radiation curable resin interposed between the bonded substrates in a non-destructive manner. Thus, the degree of curing can be made uniform for all optical

disks by discontinuing the curing of the resin when a predetermined color density is obtained.

In order to irradiate and cure the radiation curable resin from both sides, the first and second substrates are simultaneously or alternately for at least one time each, irradiated from both sides with radioactive rays. This prevents the bonded substrates from warping due to the contraction of the radiation curable resin.

Various other modifications will be apparent to and can be readily made by those skilled in the art without departing from the scope and spirit of this invention. Accordingly, it is not intended that the scope of the claims appended hereto be limited to the description as set forth herein, but rather that the claims be broadly construed.

What is claimed is:

1. A disk-shaped optical information medium comprising:

a first substrate having a center hole;

5 a second substrate having a center hole; and

a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates,

10 wherein the optical information medium further comprises a stopper for preventing the radiation curable resin from protruding into the center holes of the substrates, and

15 a space between the first and second substrates of at least a half of a clamp region for clamping the optical information medium is filled with the resin.

20 2. An optical information medium according to claim 1, wherein the stopper comprises at least one concave portion formed on at least one of the first and second substrates.

25 3. An optical information medium according to claim 2, wherein the concave portion is a ring-shaped groove which is substantially concentric with the center holes of the substrates.

4. An optical information medium according to claim 1, wherein the stopper comprises at least one concave portion formed on one of the first and second substrates and at least one convex portion formed on the other substrate.

30 5. An optical information medium according to claim 4,

wherein the concave portion is disposed to face the convex portion.

5 6. An optical information medium according to claim 1,
wherein the stopper is formed at a position closer to the
center holes of the substrates with respect to the center
of the clamp region, and the radiation curable resin
spreads to the position of the stopper.

10 7. An optical information medium according to claim 1,
wherein the stopper is formed at a position farther from
the center holes of the substrates with respect to the center
of the clamp region, and a layer of another resin
layer is formed on a portion of the substrates closer to
the center holes with respect to the stopper.

15 8. An optical information medium according to claim 7,
wherein the another resin layer comprises a radiation
curable resin having a viscosity higher than the radia-
tion curable resin for bonding the first and second
substrates.

20 9. An optical information medium according to claim 1,
wherein the stopper comprises a sealant layer.

25 10. An optical information medium according to claim 9,
wherein the sealant layer is formed by printing a radia-
tion curable resin.

30 11. An optical information medium according to claim 9,
wherein the sealant layer is made of a hot melt adhesive.

12. A disk-shaped optical information medium comprising:

a first substrate having a center hole;
a second substrate having a center hole; and
a radiation curable resin interposed between the
first and second substrates for bonding together the
first and second substrates,

wherein the optical information medium further
comprises a ring-shaped groove substantially concentric
with the center holes of the substrates, formed on at
least one of the first and second substrates at a posi-
tion closer to the center holes with respect to the
center of a clamp region for clamping the optical
information medium, and

a space between the first and second substrates
of at least a half of the clamp region is filled with the
radiation curable resin.

13. An optical information medium according to claim 12,
wherein an information signal surface is formed on a
portion of the at least one substrate closer to an outer
circumference of the substrate with respect to an outer
rim of the groove on the substrate, and a reflection film
is formed on the groove and the information signal
surface.

25 14. An optical information medium comprising a first
substrate having a center hole, a second substrate having
a center hole, and a radiation curable resin interposed
between the first and second substrates to integrate the
first and second substrates, wherein the radiation
curable resin does not exist in a region adjacent to the
center holes of the first and second substrates.

30 15. A disk-shaped optical information medium comprising:

a first substrate having a center hole;
a second substrate having a center hole; and
a radiation curable resin interposed between the
first and second substrates for bonding together the
first and second substrates,

wherein an outer circumference of at least one of
the first and second substrates is tapered.

10 16. A disk-shaped optical information medium comprising:

a first substrate having a center hole;
a second substrate having a center hole; and
a radiation curable resin interposed between the
first and second substrates for bonding together the
first and second substrates,

15 wherein the radiation curable resin has a weather-resistance pigment mixed therein.

20 17. A disk-shaped optical information medium comprising:

a first substrate having a center hole;
a second substrate having a center hole; and
a radiation curable resin interposed between the
first and second substrates for bonding together the
first and second substrates,

25 wherein the radiation curable resin comprises a
resin of which color density varies with the level of the
curing of the resin.

30 18. A method for fabricating an optical information
medium, comprising the steps of:

forming a pair of substrates each having a center
hole;

placing one of the pair of substrates on the
other substrate with a radiation curable resin interposed

therebetween; and

curing the radiation curable resin by irradiating the resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond the pair of substrates together,

wherein the step of forming a pair of substrates includes the step of forming a stopper for preventing the radiation curable resin from protruding into the center holes on at least one of the pair of substrates, and

the step of placing one of the pair of substrates on the other substrate includes the step of filling at least a half of a clamp region of the optical information medium with the radiation curable resin.

19. A method according to claim 18, wherein the step of placing one of the pair of substrates on the other substrate includes the steps of:

applying the radiation curable resin to a portion of the substrate on which the stopper is formed closer to an outer circumference of the substrate with respect to the stopper to form a donut-shaped resin layer while the substrate being rotated, placing the other substrate on the substrate with the stopper, and rotating the both substrates integrally; and

curing the radiation curable resin by irradiating the radiation curable resin with radioactive rays passing through at least one of the substrates.

20. A method according to claim 18, wherein the step of placing one of the pair of substrates on the other substrate includes the step of:

mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer

diameter of at least one of the pair of substrates so as to rotate the pair of substrates.

21. A method according to claim 18, wherein the step of placing one of the pair of substrates on the other substrate includes the step of:

mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates, and absorbing the radiation curable resin through the center holes of the pair of substrates while the pair of substrates being rotated.

22. A method according to claim 18, wherein, in the step of curing the radiation curable resin, a transparent plate having an outer diameter smaller than an outer diameter of at least one of the pair of substrates is placed on the bonded pair of substrates and the radiation curable resin is irradiated with the radioactive rays passing through the transparent plate.

23. A method for fabricating an optical information medium, comprising the steps of:

forming a pair of substrates each having a center hole;

placing one of the pair of substrates on the other substrate with a radiation curable resin interposed therebetween; and

curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond together the pair of substrates,

wherein the step of placing one of the pair of substrates on the other substrate includes the step of disposing the radiation curable resin so that the resin is away from the center holes of the substrates.

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24. A method according to claim 23, wherein the step of forming a pair of substrates includes the step of forming a stopper for preventing the radiation curable resin from protruding into the center holes on at least one of the pair of substrates.

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25. A method according to claim 24, wherein the step of placing one of the pair of substrates on the other substrate includes the steps of:

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applying the radiation curable resin to a portion of the substrate on which the stopper is formed closer to an outer circumference of the substrate with respect to the stopper to form a donut-shaped resin layer while the substrate are being rotated, forming a layer of another radiation curable resin on a portion of the substrate closer to an inner circumference with respect to the stopper, placing the other substrate on the substrate with the stopper, and rotating both substrates integral-

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ly; and

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curing the radiation curable resin by irradiating the radiation curable resin with radioactive rays passing through at least one of the pair of substrates.

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26. A method according to claim 23, wherein, in the step of curing the radiation curable resin, a transparent plate is placed on the bonded pair of substrates and the radiation curable resin is irradiated with the radioactive rays passing through the transparent plate.

27. A method according to claim 25, wherein the another radiation curable resin is applied by use of a roller.

5 28. A method for fabricating an optical information medium, comprising the steps of:

 forming a pair of substrates each having a center hole;

10 placing one of the pair of substrates on the other substrate with a radiation curable resin interposed therebetween; and

15 curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond together the pair of substrates,

20 wherein, in the step of forming a pair of substrates, an outer circumference of at least one of the pair of substrates is tapered.

25 29. A method according to claim 28, wherein the step of placing one of the pair of substrates on the other substrate includes the step of:

 shaping the radiation curable resin at outer circumferences of the pair of substrates by use of a transfer roller having a shape corresponding to a shape of a recess formed by the tapered outer circumferences of the pair of substrates.

30 30. A method according to claim 28, wherein the step of placing one of the pair of substrates on the other substrate includes the step of:

 mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as

to rotate the pair of substrates.

31. A method according to claim 28, wherein the step of placing one of the pair of substrates on the other substrate includes the step of:

mounting the pair of substrates on a rotational table having an outer diameter smaller than an outer diameter of at least one of the pair of substrates so as to rotate the pair of substrates, and absorbing the radiation curable resin through the center holes of the pair of substrates while the pair of substrates are being rotated.

32. A method according to claim 28, wherein the step of curing the radiation curable resin includes the step of placing a transparent plate having another diameter smaller than an outer diameter of at least one of the pair of substrates on the bonded pair of substrates and irradiating the radiation curable resin with the radioactive rays passing through the transparent plate.

33. A method for fabricating an optical information medium comprising the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween,

wherein a sealant layer is formed of another radiation curable resin on a portion of one of the substrates closer to an inner circumference of the substrate, the viscosity of the another radiation curable resin when it is not cured being higher than that of the radiation curable resin for bonding formed on a portion of the substrate closer to an outer circumference of the

substrate, and the radiation curable resins are cured by radioactive rays passing through the first or second substrate to bond together the first and second substrates.

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34. A method for fabricating an optical information medium comprising the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween,

wherein a sealant layer is formed by printing a radiation curable resin on a portion of one of the substrates closer to an inner circumference of the substrate, and the radiation curable resins are cured by radioactive rays passing through the first or second substrate to bond together the first and second substrates.

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35. A method for fabricating an optical information medium comprising the step of bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween,

wherein a sealant layer is formed of a hot melt adhesive on a portion of one of the substrates closer to an inner circumference of the substrate, the first and second substrates are pressed with the radiation curable resin and the sealant layer being interposed therebetween, and the radiation curable resin is cured by radioactive rays passing through the first or second substrate to bond together the first and second substrates.

36. A method for fabricating an optical information medium comprising the step of bonding together a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween,

wherein a portion of the radiation curable resin protruding into the center holes is removed before the radiation curable resin is cured.

10 37. A method according to claim 36, wherein the portion of the radiation curable resin protruding into the center holes is removed by use of a jig.

15 38. A method according to claim 36, wherein the portion of the radiation curable resin protruding into the center holes is removed by absorbing through a suction port disposed on a boss of a spindle for rotating the substrates.

20 39. A method according to claim 36, wherein the portion of the radiation curable resin protruding into the center holes is removed by absorbing by a sponge disposed on a boss of a spindle for rotating the substrates.

25 40. A method for fabricating an optical information medium, comprising the steps of:

placing one of a pair of substrates, each having a center hole, on the other substrate with a radiation curable resin interposed therebetween; and

30 curing the radiation curable resin with radioactive rays capable of passing through at least one of the pair of substrates so as to bond together the pair of substrates,

wherein a resin of which color density varies with the degree of the curing of the resin is used as the radiation curable resin, the color density of the resin is measured when the resin is irradiated with radioactive rays, and the curing of the resin is terminated when the resin obtains a predetermined color density.

41. A method for fabricating an optical information medium comprising the step of bonding a first substrate and a second substrate with radiation curable resin interposed therebetween,

wherein radioactive rays passing through the first substrate and radioactive rays passing through the second substrate radiate the radiation curable resin so as to cure the radiation curable resin.

42. A method according to claim 41, wherein at least one of radiation intensity and duration of the radioactive rays is adjusted according to a radioactive ray transmittance of the substrate through which the radioactive rays pass.

43. An apparatus for fabricating an optical information medium, comprising:

means for applying a radiation curable resin, while a first substrate having a stopper for preventing the radiation curable resin from protruding into a center hole being rotated, to a portion of the first substrate closer to an outer circumference of the first substrate with respect to the stopper, to form a donut-shaped resin layer;

means for placing a second substrate on the first substrate;

means for rotating the first and second substrates integrally; and

means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

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44. An apparatus according to claim 43, further comprising means for placing a transparent plate on the bonded substrates.

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45. An apparatus according to claim 43, further comprising means for applying another radiation curable resin to a portion of the substrate closer to an inner circumference of the substrate with respect to the stopper.

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46. An apparatus according to claim 45, wherein the means for applying another radiation curable resin includes any of brush means, roller means, and clean printing means.

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47. An apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, comprising:

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means for applying a first radiation curable resin on a portion of the first substrate closer to an inner circumference of the first substrate and applying a second radiation curable resin having a viscosity lower than the first radiation curable resin to a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated;

means for placing the second substrate on the

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first substrate;

means for rotating the first and second substrates integrally; and

5 means for irradiating the radiation curable resins with radioactive rays passing through at least one of the first and second substrates.

48. An apparatus for fabricating an optical information medium by bonding a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, comprising:

10 means for applying a portion of the radiation curable resin on a portion of the first or second substrate closer to an inner circumference of the first or second substrate;

15 means for applying the remainder of the radiation curable resin on a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated;

20 means for placing the second substrate on the first substrate;

means for rotating the first and second substrates integrally; and

25 means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

30 49. An apparatus for fabricating an optical information medium by bonding together a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, comprising:

means for applying a hot melt adhesive to a portion of the first or second substrate closer to an inner circumference of the first or second substrate;

5 means for applying the radiation curable resin to a portion of the first substrate closer to an outer circumference of the first substrate while the first substrate is being rotated;

means for placing the second substrate on the first substrate;

10 means for rotating the first and second substrates integrally; and

means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates.

15 50. An apparatus for fabricating an optical information medium by bonding together a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, comprising:

a table for integrally rotating the first and second substrates with the radiation curable resin before being cured interposed therebetween; and

25 means for absorbing the radiation curable resin interposed between the first and second substrates through the center holes of the first and second substrates.

30 51. An apparatus for fabricating an optical information medium by bonding together a first substrate having a center hole and a second substrate having a center hole with a radiation curable resin interposed therebetween, comprising:

means for irradiating the radiation curable resin with radioactive rays passing through at least one of the first and second substrates; and

means for measuring a color density of the
radiation curable resin.

52. A method according to claim 18, wherein, in the step of curing the radiation curable resin, the radioactive rays are reflected near the outer circumferences of the substrates placed on each other to irradiate the outer circumferences of the substrates.

10 53. A method according to claim 28, wherein, in the step of curing the radiation curable resin, the radioactive rays are reflected near the outer circumferences of the substrates placed on each other to radiate the outer circumferences of the substrates.

15 54. A method according to claim 52, wherein the radioactive rays are reflected by a mirror of a truncated cone shape disposed to surround the outer circumferences of the substrates.

20 25 55. A method according to claim 52, wherein the radioactive rays are reflected by a mirror of a truncated cone shape disposed to surround the outer circumferences of the substrates.

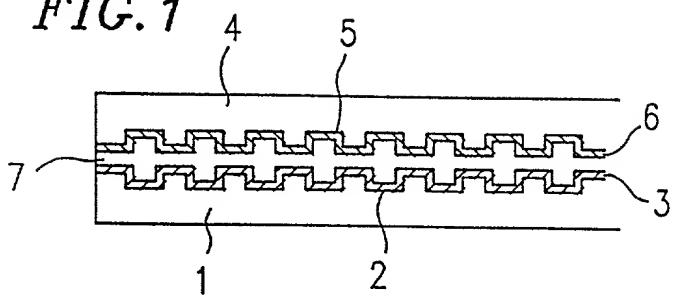
30 56. An apparatus according to claim 43, further comprising means for irradiating the outer circumferences of the substrate placed on each other with the radioactive rays.

ABSTRACT OF THE DISCLOSURE

The disk-shaped optical information medium of this invention includes: a first substrate having a center hole; a second substrate having a center hole; and a radiation curable resin interposed between the first and second substrates for bonding together the first and second substrates, wherein the optical information medium further includes a stopper for preventing the radiation curable resin from protruding into the center holes of the substrates, and a space between the first and second substrates of at least a half of a clamp region for clamping the optical information medium is filled with the resin.

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FIG. 1



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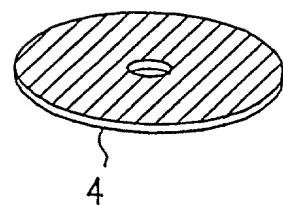
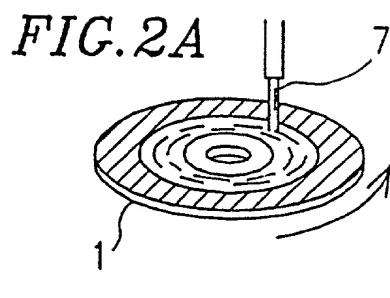


FIG. 2B

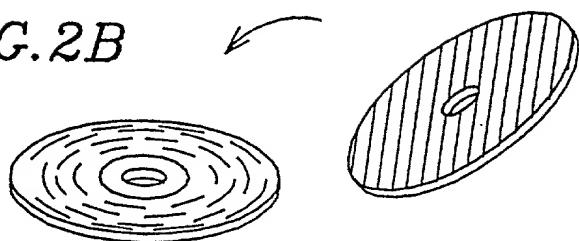


FIG. 2C

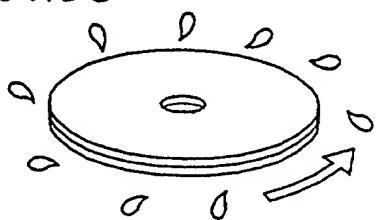
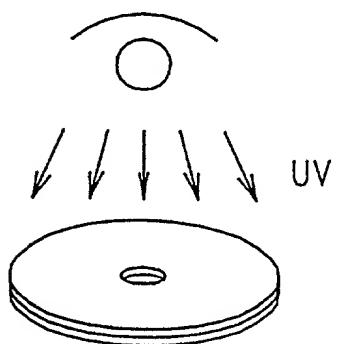
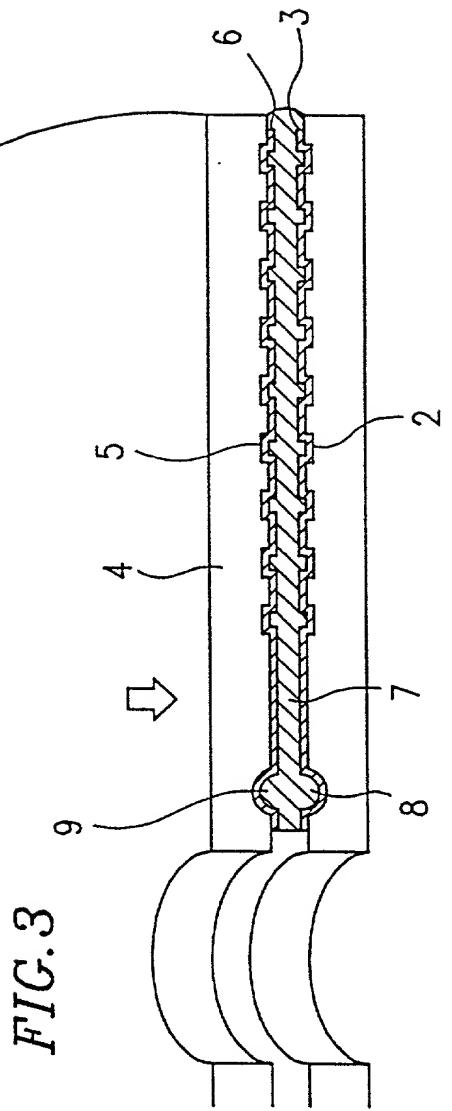


FIG. 2D

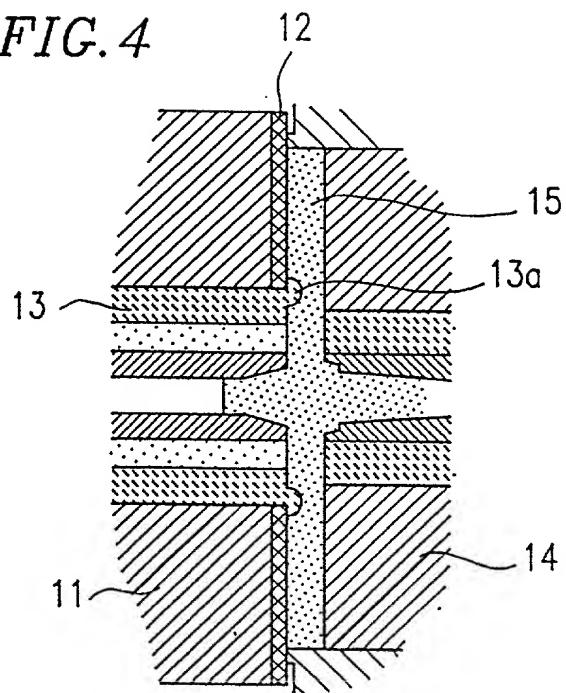


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FIG. 4



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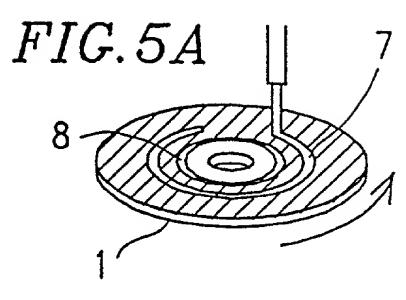


FIG. 5B

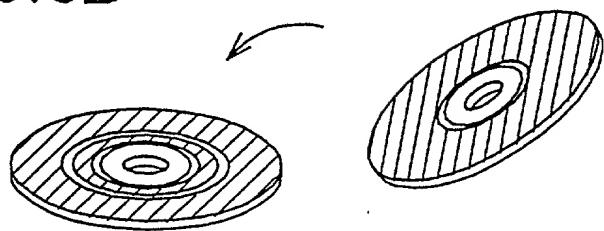


FIG. 5C

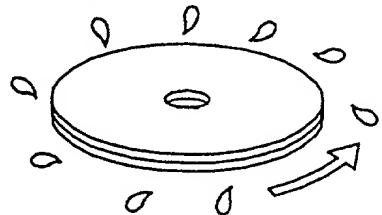
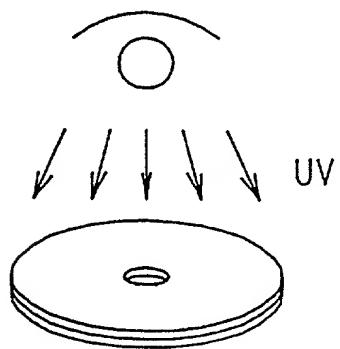
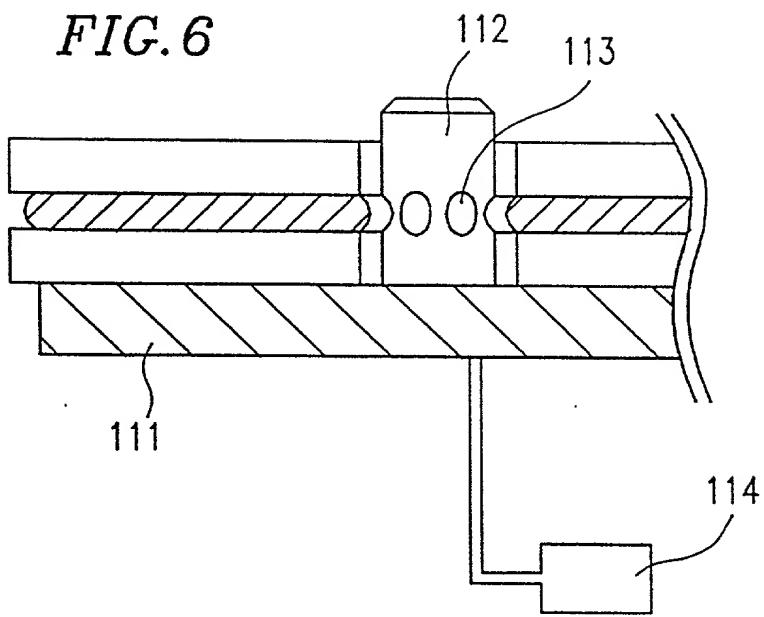


FIG. 5D



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FIG. 6



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FIG. 7

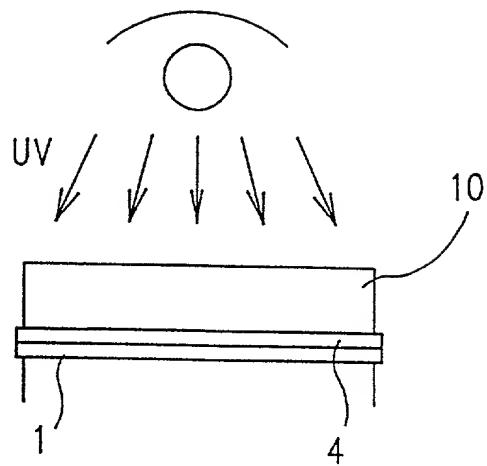
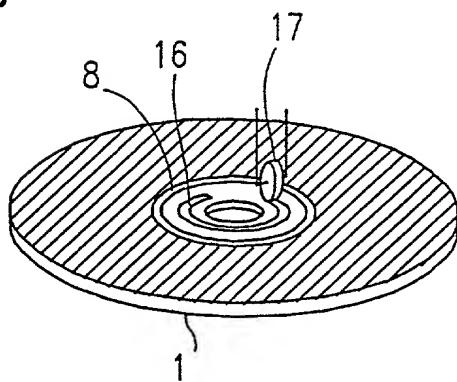


FIG. 8



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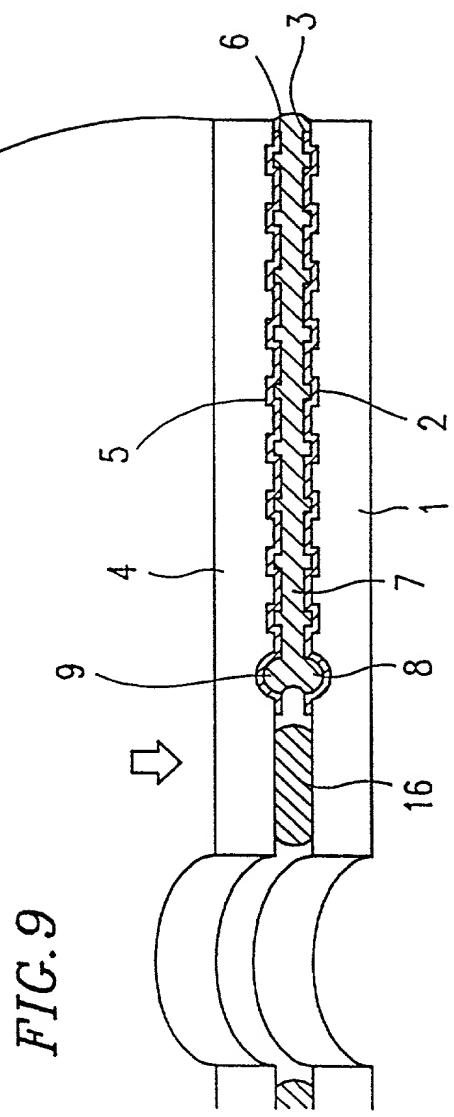
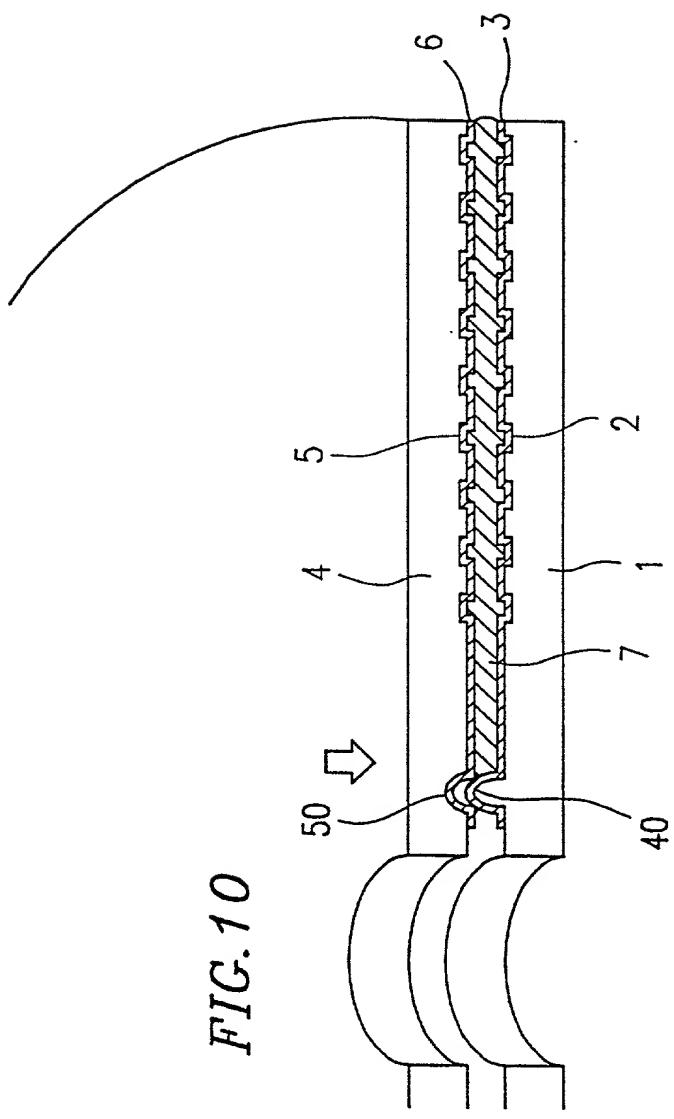


FIG. 9

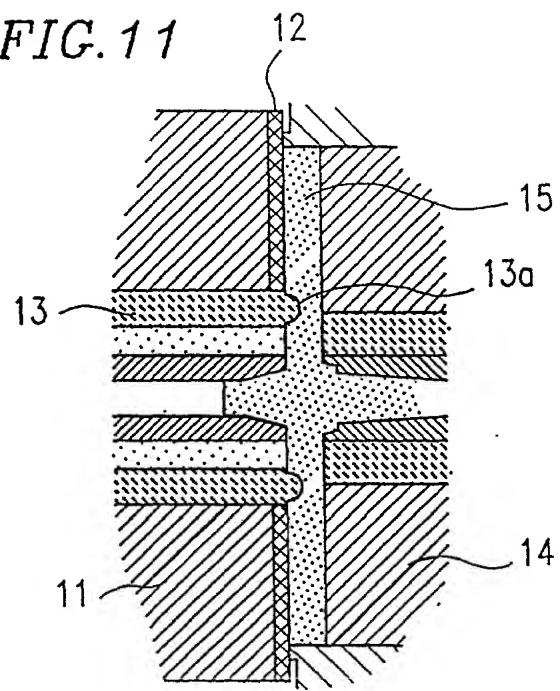
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FIG. 10



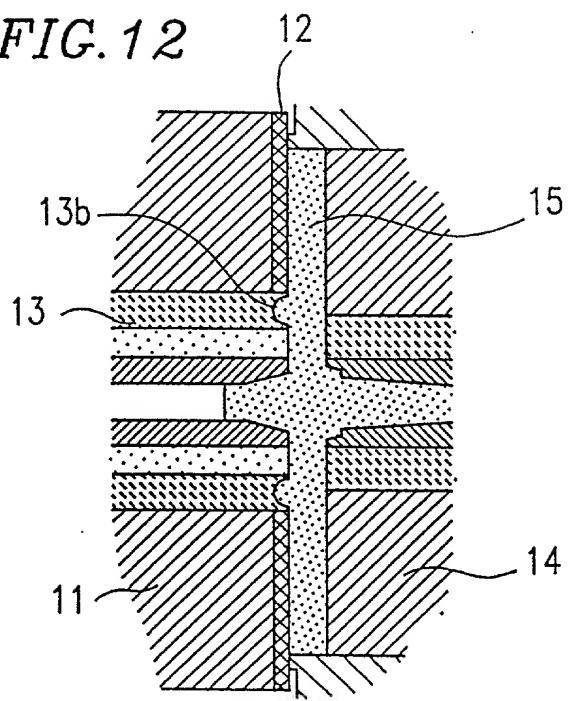
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FIG. 11



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FIG. 12



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FIG. 13A

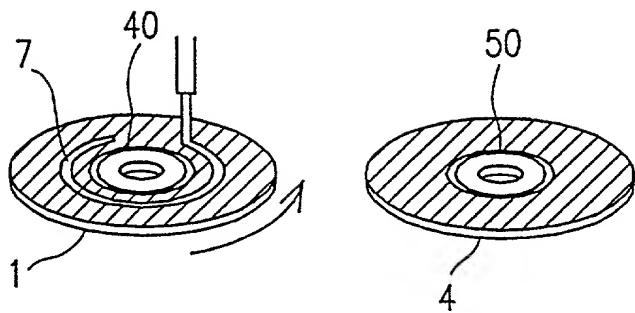


FIG. 13B

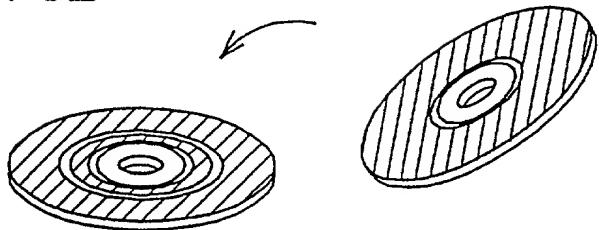


FIG. 13C

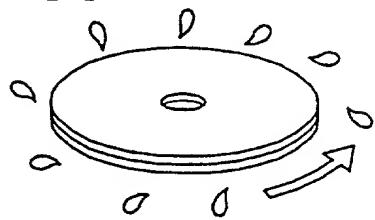
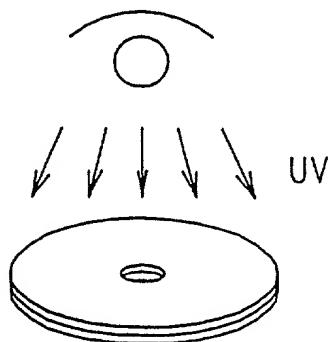


FIG. 13D



P13331

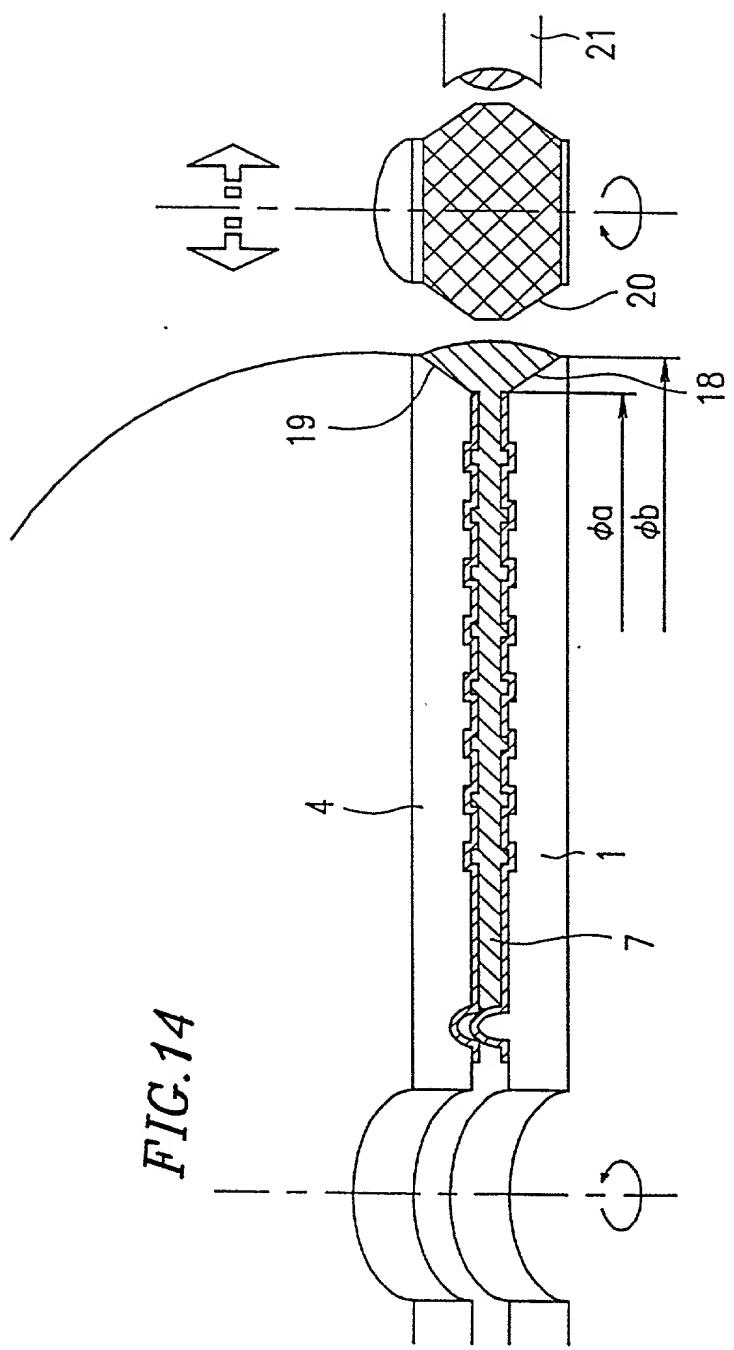
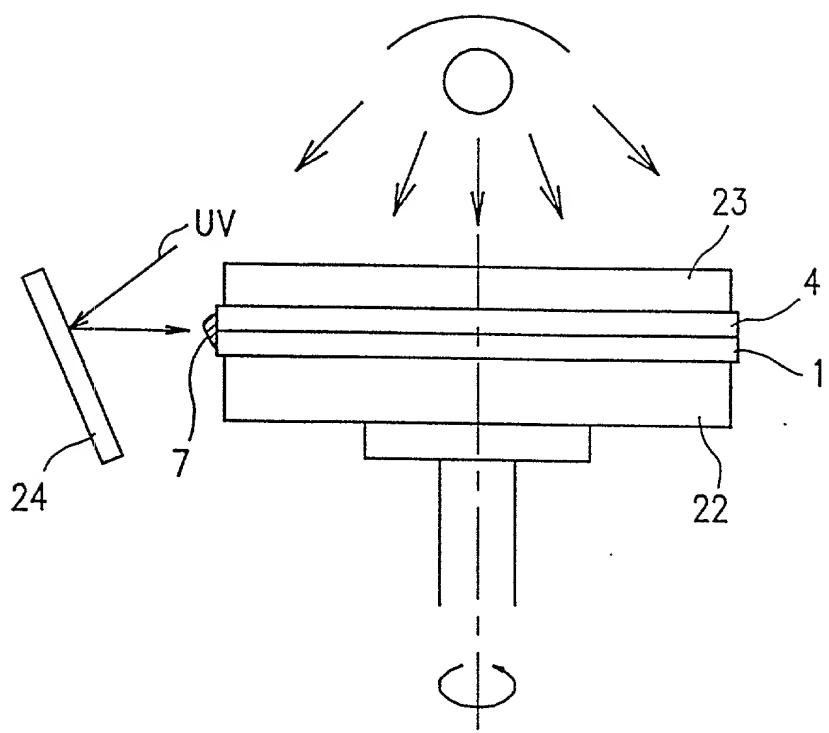


FIG.14

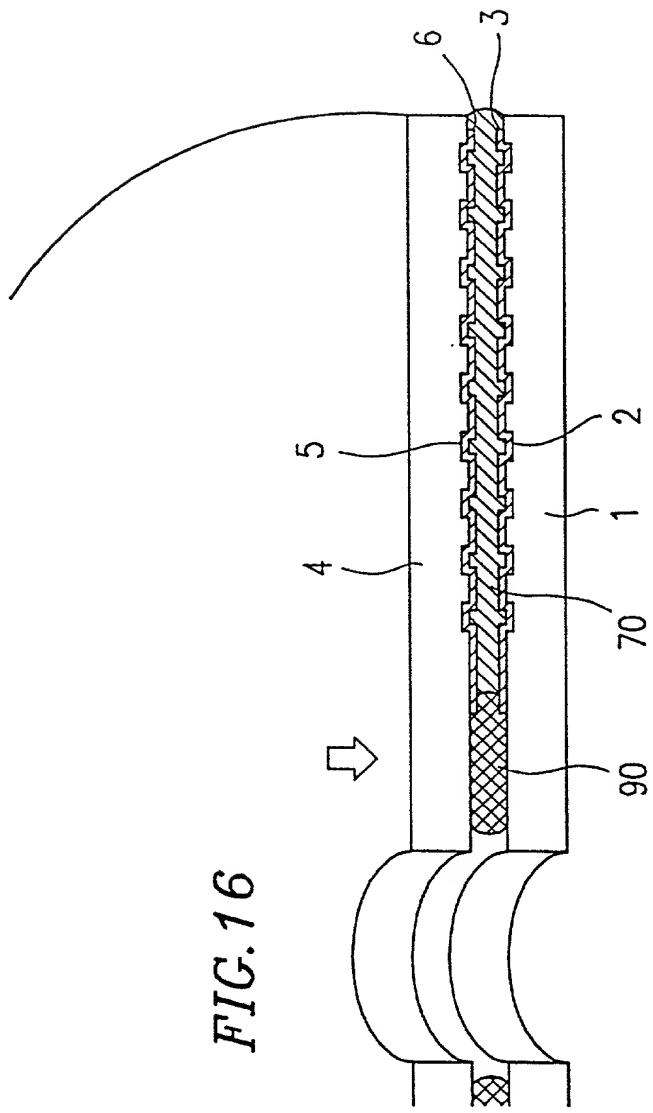
P13331

FIG. 15



P13331

FIG. 16



P13331

FIG. 17A

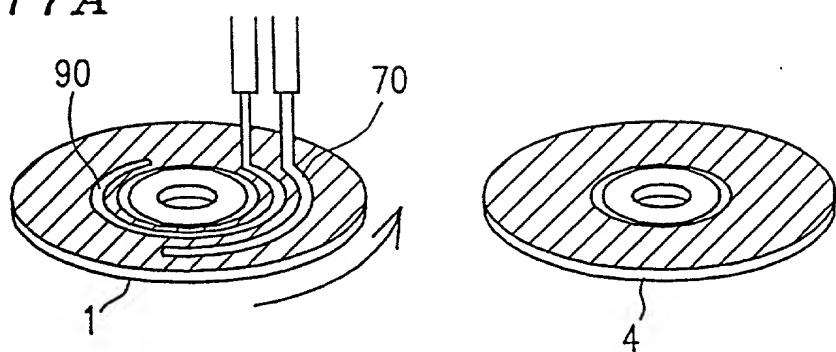


FIG. 17B

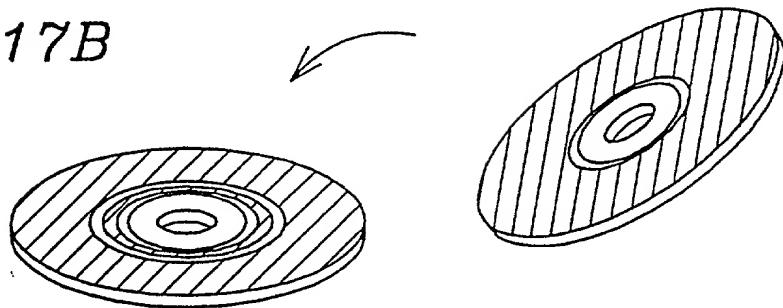


FIG. 17C

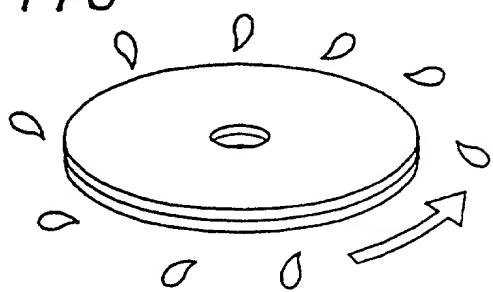


FIG. 17D

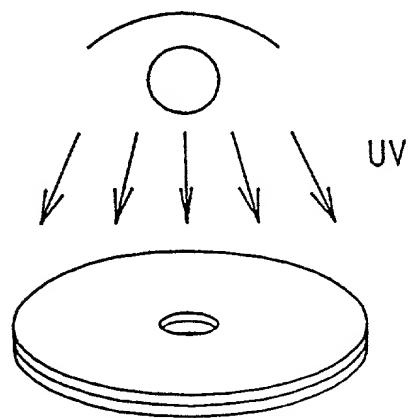


FIG. 18

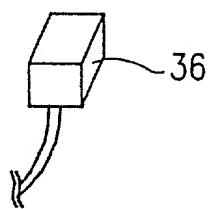
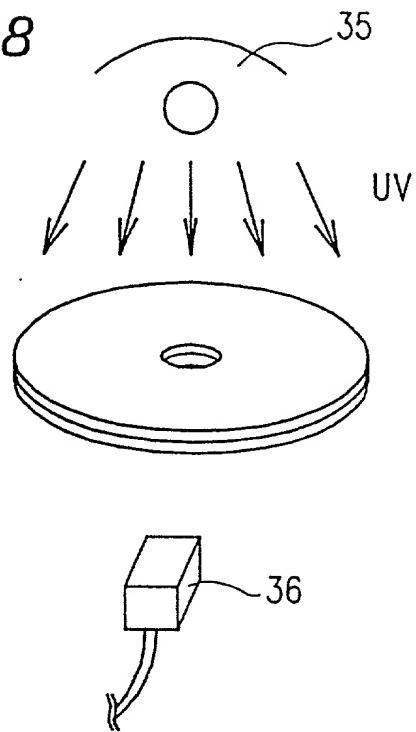
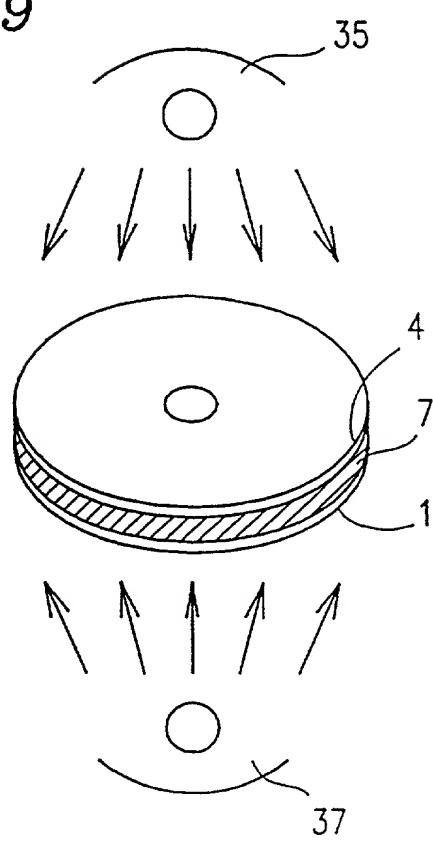


FIG. 19



PATENT

Attorney's Docket No. _____

COMBINED DECLARATION AND POWER OF ATTORNEY(ORIGINAL, DESIGN, NATIONAL STAGE OF PCT, SUPPLEMENTAL, DIVISIONAL,
CONTINUATION OR CIP)

As a below named inventor, I hereby declare that:

TYPE OF DECLARATION

This declaration is of the following type: (check one applicable item below)

- original
 design
 supplemental

NOTE: If the declaration is for an International Application being filed as a divisional, continuation or continuation-in-part application, do not check next item; check appropriate one of last three items.

- national stage of PCT

NOTE: If one of the following 3 items apply, then complete and also attach ADDED PAGES FOR DIVISIONAL, CONTINUATION OR CIP.

- divisional
 continuation
 continuation-in-part (CIP)

INVENTORSHIP IDENTIFICATION

WARNING: If the inventors are each not the inventors of all the claims, an explanation of the facts, including the ownership of all the claims at the time the last claimed invention was made, should be submitted.

My residence, post office address and citizenship are as stated below next to my name. I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

TITLE OF INVENTION

**OPTICAL INFORMATION MEDIUM, AND METHOD AND APPARATUS FOR
FABRICATING THE SAME
SPECIFICATION IDENTIFICATION**

the specification of which: (complete (a), (b) or (c))

- (a) is attached hereto.
 (b) was filed on _____ as Serial No. 0 / _____
 or Express Mail No., as Serial No. not yet known _____
 and was amended on _____ (if applicable).

NOTE: Amendments filed after the original papers are deposited with the PTO which contain new matter are not accorded a filing date by being referred to in the declaration. Accordingly, the amendments involved are those filed with the application papers or, in the case of a supplemental declaration, are those amendments claiming matter not encompassed in the original statement of invention or claims. See 37 CFR 1.67.

- (c) was described and claimed in PCT International Application No. _____ filed on _____ and as amended under PCT Article 19 on _____ (if any).

ACKNOWLEDGEMENT OF REVIEW OF PAPERS AND DUTY OF CANDOR

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information

- which is material to patentability as defined in 37, Code of Federal Regulations, § 1.56

(also check the following items, if desired)

- and which is material to the examination of this application, namely, information where there is a substantial likelihood that a reasonable examiner would consider it important in deciding whether to allow the application to issue as a patent, and
- In compliance with this duty there is attached an information disclosure statement in accordance with 37 CFR 1.98.

PRIORITY CLAIM (35 U.S.C. § 119)

I hereby claim foreign priority benefits under Title 35, United States Code, § 119 of any foreign application(s) for patent or inventor's certificate or of any PCT International application(s) designating at least one country other than the United States of America listed below and have also identified below any foreign application(s) for patent or inventor's certificate or any PCT International application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed.

(complete (d) or (e))

- (d) no such applications have been filed.
(e) such applications have been filed as follows.

NOTE: Where item (c) is entered above and the International Application which designated the U.S. itself claimed priority check item (e), enter the details below and make the priority claim.

A. PRIOR FOREIGN/PCT APPLICATION(S) FILED WITHIN 12 MONTHS (6 MONTHS FOR DESIGN) PRIOR TO THIS APPLICATION AND ANY PRIORITY CLAIMS UNDER 35 U.S.C. § 119

COUNTRY (OR INDICATE IF PCT)	APPLICATION NUMBER	DATE OF FILING (day, month, year)	PRIORITY CLAIMED UNDER 37 USC 119
Japan	7-27086	15,02,1995	<input checked="" type="checkbox"/> YES NO <input type="checkbox"/>
Japan	7-58934	17,03,1995	<input checked="" type="checkbox"/> YES NO <input type="checkbox"/>
Japan	7-58933	17,03,1995	<input checked="" type="checkbox"/> YES NO <input type="checkbox"/>
			<input type="checkbox"/> YES NO <input type="checkbox"/>
			<input type="checkbox"/> YES NO <input type="checkbox"/>

(Declaration and Power of Attorney [1-1]—page 2 of 5)

**ALL FOREIGN APPLICATION(S), IF ANY FILED MORE THAN 12 MONTHS
(6 MONTHS FOR DESIGN) PRIOR TO THIS U.S. APPLICATION**

NOTE: If the application filed more than 12 months from the filing date of this application is a PCT filing forming the basis for this application entering the United States as (1) the national stage, or (2) a continuation, divisional, or continuation-in-part, then also complete ADDED PAGES TO COMBINED DECLARATION AND POWER OF ATTORNEY FOR DIVISIONAL, CONTINUATION OR CIP APPLICATION for benefit of the prior U.S. or PCT application(s) under 35 U.S.C. § 120.

POWER OF ATTORNEY

I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (List name and registration number)

Armand P. Boisselle
Reg. No. 22,381

(check the following item, if applicable)

- Attached as part of this declaration and power of attorney is the authorization of the above-named attorney(s) to accept and follow instructions from my representative(s).

SEND CORRESPONDENCE TO

Armand P. Boisselle
Renner, Otto, Boisselle & Sklar
The Keith Building
1621 Euclid Avenue - 19th Fl.
Cleveland, Ohio 44115

DIRECT TELEPHONE CALLS TO:
(Name and telephone number)

Armand P. Boisselle
216/621-1113

DECLARATION

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

SIGNATURE(S)

NOTE: Carefully Indicate the family (or last) name as it should appear on the filing receipt and all other documents.

Full name of sole or first inventor

Hisaki

MIYAMOTO

(GIVEN NAME)

(MIDDLE INITIAL OR NAME)

FAMILY (OR LAST NAME)

Inventor's signature Hisaki Miyamoto

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Osaka-shi, Osaka Japan

(Declaration and Power of Attorney [1-1]—page 4 of 5)

CHECK PROPER BOX(ES) FOR ANY OF THE FOLLOWING ADDED PAGE(S) WHICH
FORM A PART OF THIS DECLARATION

- Signature for third and subsequent joint inventors. Number of pages added 1
- * * *
- Signature by administrator(trix), executor(trix) or legal representative for deceased or incapacitated inventor. Number of pages added _____
- * * *
- Signature for inventor who refuses to sign or cannot be reached by person authorized under 37 CFR 1.47. Number of pages added _____
- * * *
- Added page for signature by one joint inventor on behalf of deceased inventor(s) where legal representative cannot be appointed in time (37 CFR 1.47).
- * * *
- Added pages to combined declaration and power of attorney for divisional, continuation, or continuation-in-part (C-I-P) application.
 Number of pages added _____
- * * *
- Authorization of attorney(s) to accept and follow instructions from representative.

(If no further pages form a part of this Declaration, then end this Declaration with this page and check the following item:)

- This declaration ends with this page.

ADDED PAGE TO COMBINED DECLARATION AND POWER OF
ATTORNEY FOR SIGNATURE BY FOURTH AND SUBSEQUENT INVENTORS

Full name of fourth joint inventor, if any

Sakae

(GIVEN NAME)

(MIDDLE INITIAL OR NAME)

NODA

FAMILY (OR LAST NAME)

Inventor's signature Sakae Noda

Date February 1, 1996 Country of Citizenship Japan

Residence Katano-shi, Osaka Japan

Post Office Address 3-13-9, Kuraji, Katano-shi, Osaka Japan

Full name of fifth joint inventor, if any

(GIVEN NAME)

(MIDDLE INITIAL OR NAME)

FAMILY (OR LAST NAME)

Inventor's signature _____

Date _____ Country of Citizenship _____

Residence _____

Post Office Address _____

Full name of sixth joint inventor, if any

(GIVEN NAME)

(MIDDLE INITIAL OR NAME)

FAMILY (OR LAST NAME)

Inventor's signature _____

Date _____ Country of Citizenship _____

Residence _____

Post Office Address _____